

# KD300/500 电机用户手册

## KD300/500 Motor MANUAL

### 1、产品示意图 Product Diagram



#### 产品优势:

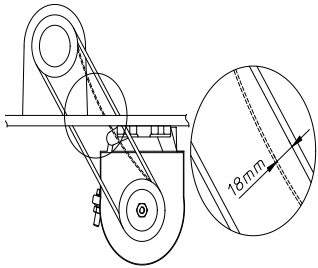
- 一发着针及适用各种针车的简便调整设定
- 适用于平车、高车头、特种车及各种高惯车头
- 高扭力，低振动，低噪音
- 软硬體双层保护系统，品质更稳定

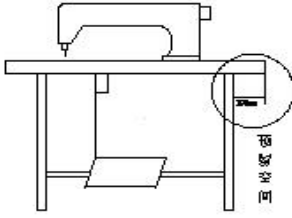
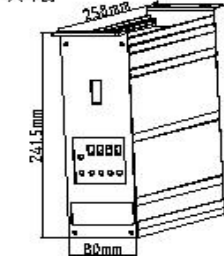
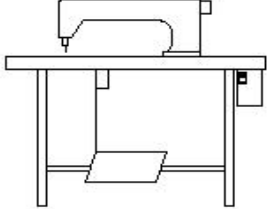
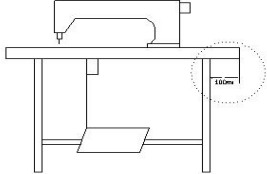
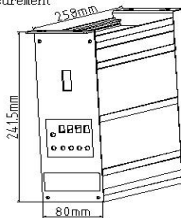
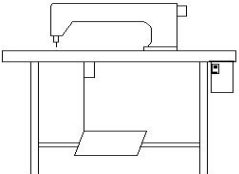
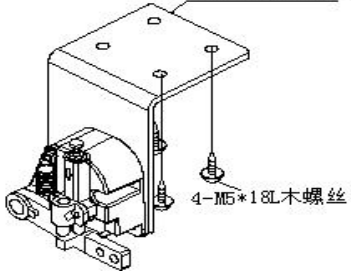
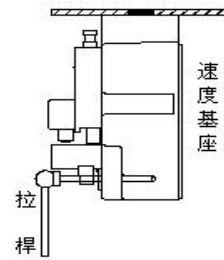
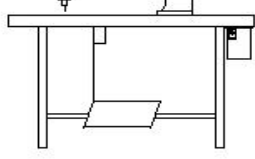
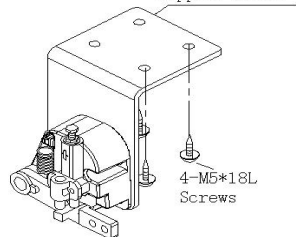
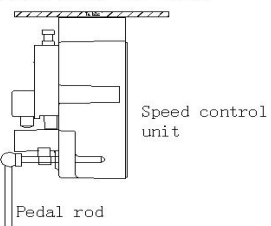
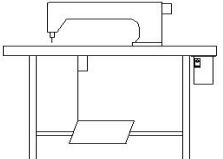
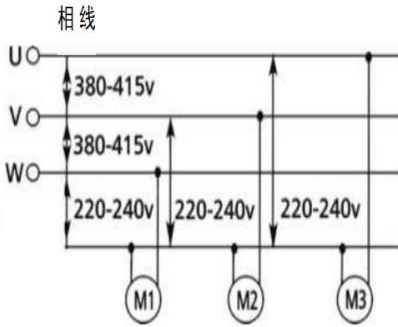
#### Advantages:

- Right on position and matches with various sewing machines and easy to exchange
- For lockstitch, heavy duty, height post and special machines
- High power, low vibration and low noise
- Software and Hardware has 2 way protection system, reliable quality

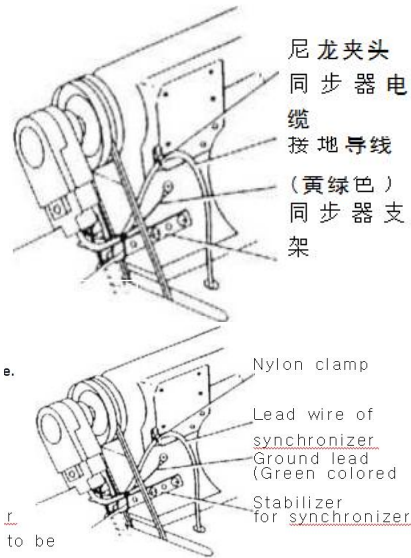
### 2. 安装调整说明 Installation and Adjustment Instructions

直驱马达组装说明另有附件 Direct Motor Assemble Manual is attached later

安装项目 Installation project	图示 Diagram	描述说明 Description
皮带安装 Belt Installation		<p>在皮带中间施加1kgf, 绷紧皮带垂直下垂18mm左右. When a force of 1 kg is applied in the center of the belt, tighten the belt to an extent that it sags by approx, 18mm.</p> <ol style="list-style-type: none"> <li>1. 拧松上下端皮带调节螺丝, 仅用皮带来支撑马达 Loosen the belt adjusting screws at the upper and lower sides, and support the motor with only the belt.</li> <li>2. 拧紧上端的皮带调节螺丝, 然后在加了负载后螺丝的位置上再拧紧一圈 Tighten the belt adjusting screw at the upper side and re-tighten it one more turn from the position in which the load is applied to the screw.</li> <li>3. 拧紧下端皮带调节螺丝并检查无误为止 Tighten it with the belt adjusting screw at the lower side and secure it.</li> </ol>

<p>控制盒安装 Control Box Installation</p>	<p>a). 车版右侧面须预留100mm以上空间</p>  <p>b.) 将控制箱锁装于车板下方 尺寸图</p>  <p>c). 安装后示意图</p> 
	<p>a). leave 100mm space at right</p>  <p>b.) Mounting under the working table Measurement</p>  <p>c). Installation layout</p> 
<p>调速开关安装 Speed Control Unit Installation</p>	<p>速度基座与其支架 速度基座固定铁板</p>  <p>4-M5*18L木螺丝</p> <p>b.) 保持在拉杆成直线下，将速度基座连座锁于车板下方</p>  <p>速度基座</p> <p>拉 桿</p> <p>c). 安装后示意图</p> 
	<p>a). Speed Control Unit Support stand</p>  <p>4-M5*18L Screws</p> <p>b.) Keep rod in vertical, secure the unit under the table</p>  <p>Speed control unit</p> <p>Pedal rod</p> <p>c). Installation layout</p> 
<p>接线与接地 Wiring and Grounding</p>	 <p>相线</p> <p>U0</p> <p>V0</p> <p>W0</p> <p>0</p> <p>380-415v</p> <p>380-415v</p> <p>220-240v</p> <p>220-240v</p> <p>220-240v</p> <p>M1</p> <p>M2</p> <p>M3</p> <ol style="list-style-type: none"> <li>接线时，请遵照有关规定进行，并要特别注意安全 When wiring, please follow the National Electrical Code Standards and electric power company provisions, while and paying particular attention to safety.</li> <li>按动开头内有一个黄绿色头，此端必须要接地The push button switch is provided with a green grounding conductor: always ground this.</li> <li>电源是 380V-415V 的接线方式 Connection to high voltage power source (380-415V) 在每根相线与零线之间接马达Connect the motor between neutral point to each power line 用万用表确认电压为 220V -240VConfirm the voltage is 220V - 240V, and set the voltage select switch to right position 有多个马达时，要考虑三相平衡Balance each line load in connecting multiple motors</li> </ol>

**SY2外置同步器**  
SY2  
Synchronizer(Optional Components)



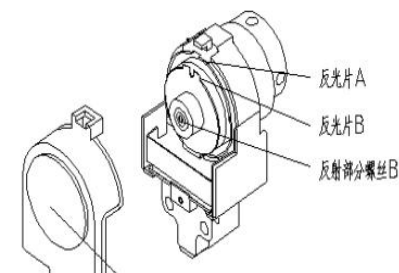
把同步器固定在缝纫机的手轮上，锁紧心轴上的2个内六角螺丝。

注意：从同步器出来的电缆线应该用尼龙带固定好，接地端子必须锁在缝纫机上。

Attach the synchronizer to the hand wheel of the sewing machine.

If adjustments of the synchronizer are necessary, please refer the "ADJUSTMENT "

NOTE: The cable extending from the synchronizer should be fixed to the retaining bolt with the band. The grounding terminal must be affixed on the sewing machine



停针位置调整:

虽然在出厂前已调整好，但在必要时，按如下方法，转动同步器的反光片来重新调整停针位置。

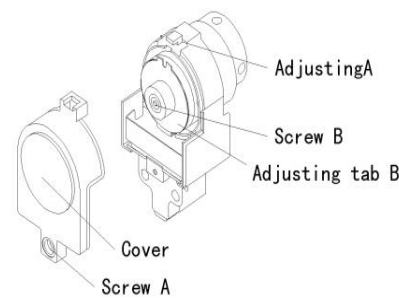
注意：在重新调整针位时，剪线器与拨线器的电磁铁断开，不要触摸光片的反射部分

a).卸下同步器的罩子（卸下螺丝 A）

b).松开螺丝 B (不要卸下)。

调整时，除了前面的步骤外，还需用脚踏板操作缝纫机。踏板轻轻前踏，然后松开，按住反光片 A,转动手轮至下针位，再后踏踏板，按住反光片 B, 转动手轮至上针位，锁紧螺丝 B, 试运转针车，定位正确后，安装好同步器罩子，最后锁紧螺丝 A

注意：在缝纫机工作时，不要触摸同步器的反射盘或其它转动部件。记住调整时电源是接通的。



Adjustment of the needle stop positions :

At factory it is pre-adjusted. However, if necessary re-adjust the needle stop positions by turning the reflection plates of the synchronizer as described below:

NOTE: While re-adjust the positions, trimmer and wiper solenoids should be disconnected. Don't touch the reflecting portions of the plates.

.Turn the sewing machine manually into the "needle down " position. (MAKE SURE THE DIRECTION OF ROTATION IS CORRECT)

.Remove the cover from the synchronizer. (Remove screw A)

.Loosen screw B. (Don't remove screw B.)

Turn the reflection plate A so that the adjusting tab of plate A will be at located position.Turn the sewing machine to the "needle up"

position.Make the same adjustment of the reflection plate B

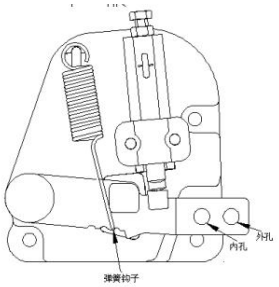
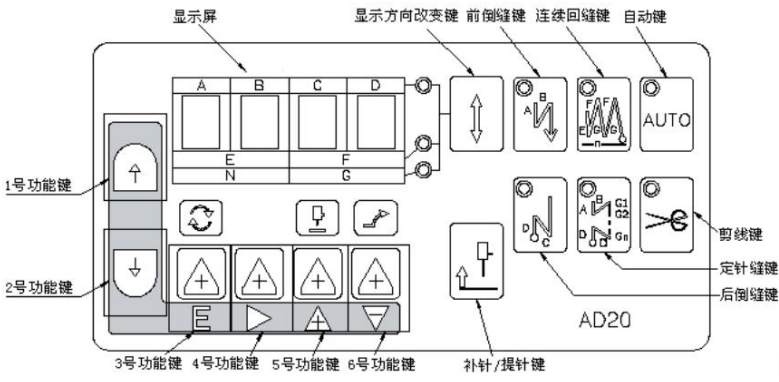
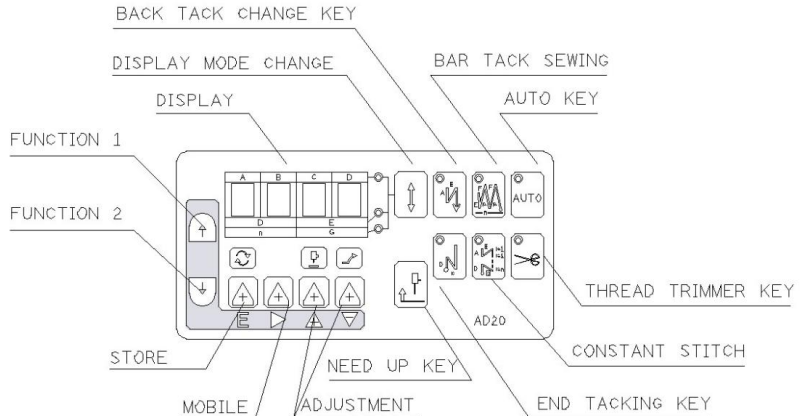
for "needle up" position.Tighten screw B.Place the cover on

the synchronizer. To make fine adjustments, follow he

receding instructions:Operate the sewing machine with the

foot pedal.Press the pedal forward and release.Make sure the

sewing machine is in the "needle down" position.Correct for



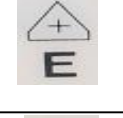







		<p>required needle position by turning the adjusting tab A.Heel the pedal. (Needle stops in the up position)</p> <p>Correct for the required position by turning the adjusting tab B.Finally tighten screw B and install the synchronizer cover.</p> <p>Note: Do not touch the reflector or other rotating parts of the synchronizer while the sewing machine is working. Remember that the power supply is switched on during the adjustment.</p>
<p><b>控速器的调整</b> speed controller Adjustment</p>	 <p>弹簧钩子</p>	<p>在调整前，确认电源已关闭</p> <p>a).改变踏板弹簧钩子调整踏板力</p> <p>b).用外孔安装踏杆,前踩踏板只要较小的力</p> <p>c).用内孔安装踏杆,前踩踏板要比较大的力</p> <p>Before starting any adjustment, be sure to turn the power switch "OFF".</p> <p>a). Change pedal-spring hook</p> <p>b). Use external hole to set pedal</p> <p>c). To make the pedal lighter, adjust by internal hole</p>
<p><b>AD20选针盒</b> (平车机种专用) AD20Console (For lockstitch)</p>	 <p>显示屏 显示方向改变键 前倒缝键 连续回缝键 自动键</p> <p>1号功能键 2号功能键 3号功能键 4号功能键 5号功能键 6号功能键</p> <p>补针/提针键</p> <p>剪线键 定针缝键 后倒缝键</p> <p>AD20</p>	<p>一般通电情况下控制箱默认自由缝(花样1), 显示屏显示内容为来回缝的针数, 3~6 功能键选择针数</p> <ul style="list-style-type: none"> <li>指示灯亮表示功能开启</li> </ul>
	 <p>BACK TACK CHANGE KEY</p> <p>DISPLAY MODE CHANGE</p> <p>DISPLAY</p> <p>FUNCTION 1</p> <p>FUNCTION 2</p> <p>STORE</p> <p>MOBILE</p> <p>ADJUSTMENT</p> <p>NEED UP KEY</p> <p>AD20</p> <p>THREAD TRIMMER KEY</p> <p>CONSTANT STITCH</p> <p>END TACKING KEY</p> <p>BAR TACK SEWING</p> <p>AUTO KEY</p>	<p>When turn ON, it is set at start tacking and end tacking (Pattern 1) , screen will show the number of stitches , use function key 3~6 to choose.</p> <ul style="list-style-type: none"> <li>Light switch on means ready to function</li> </ul>

### 3.面板各按键及显示功能详细说明

Detailed description of buttons and display functions on the operation panel

#### 3.1 主界面各按键及显示功能详细说明

Main interface each key and display function detailed description

功能 Function	显示/按键 Display/Button	图形 Graph	描述说明 Description
功能 Function (通用屏 Universal screen)	1号功能键 Function 1		主键：同其它键组合进行出厂复位、机型选择等 Primary key: combined with other keys for factory reset, model selection, etc
	2号功能键 Function 2		主键：同其它键组合进行机型选择等 Primary key: Combine with other keys for model selection, etc
	存储键 Store		同其它键组合进行出厂复位和特殊参数调用保存 Factory reset and special parameter calls in combination with other key
	移动键 Mobile		同其它键组合进行出厂复位等 Factory reset with other key combinations
	调整键 Adjust		同其它键组合进行机型选择及参数大小调整Combine with other keys for model selection and parameter size adjustment
	压脚选择键 Press foot select		一、二段压脚选择 First and second section press foot selection
	剪线开关 cutting switch		剪线功能选择 Wire cutting function selection
	上下停针键 Up and down stop pin		上下停针选择 Up and down stop needle selection
	慢速启动键 Slow start		开启慢起动 Start slow start
	显示屏 Display screen		显示参数 Display parameter

### 3.2 主参数调整详细说明

Main parameter adjustment details

开启电源后操作 POWER OFF

参数模式 Parameter Type	操作说明 Setting	功能说明 Function
出厂恢复 Reset to Factory Setting	1.关闭电源；2.按住“↑”开机，显示“A 1”； 3.同时按“↑”+“E”，显示“S---”；4.按“▷” 显示“C-31”；5.同时按“↑”和“+”或“-”选 择不同的软件版本；6.按“E”进行复位；7.复位 成功，显示“POFF”；8.关机重启	1.D9 及大和Y2 选择软件版本C-31; D9 and Yamato Y2 Select software version C-31 2.DD9 选择软件版本C-32; DD9 Select software version C-32
	1.POWER OFF ; 2.Holding [↑],POWER ON,will appear on display [A 1]; 3.Press same time [↑]&[E],will appear on display [S ---];4.Press [▷],will appear on display [C-31];5.Press same time [↑]& [+ or -] select different software versions;6.Press [E] to begin RESET function;7. Reset successfully,will appear on display [ POFF ] ; 8.POWER OFF	3.大和Y3 选择软件版本C-34; Yamato Y3 Select software version C-34 4.大和Y4 选择软件版本C-36; Yamato Y3 Select software version C-36



最高速度 Max. Speed	↑键和↓键同时按住2秒 Press ↑ and ↓ together	显示屏会显示速度值，再按↑或↓键可进行速度调整 Screen will show speed, Press ↑ or ↓ to adjust
运转方向 Rotating Direction	先按住↑键再按E键2秒 Press ↑ then E key for 2 sec	“↺”方向变“↻”方向 “↺” direction change to “↻” direction
上/下停针位 Needle up/down position	先按住↑键，再按+键2秒 Press ↑ the press + key for 2 sec	显示屏上方框为上针位，下方框为下针位 Upper position of the screen shows needle up and bottom shows needle down
慢速启动 Slow start	先按住↑键，再按-键2秒 Press ↑ then press - key for 2 sec	显示屏图示曲折为慢速启动 Screen showing bent sign “Z” mean slow start function
以下为AD20选针盒屏显 <b>Following is the screen display of AD20 needle box selection</b>		
提针 Needle up/forward stitch correction	按补针/提针键 Press needle up/forward stitch correction key	下停时有提针功能，需连续补针功能，设参数（需设定参数A1=1） Needle up stitch at needle down position, continuous forward stitch function, set parameter to A1=1
无底线 bobbing thread counting function	按↑键后重新计 Press ↑ to restart needle count	无底线时显示屏会显示“□□□□” When at bobbing thread counting function, screen will show “□□□□”
自由缝(花样1) start tacking and end tacking (Pattern 1)	连续回缝、定针缝指示灯不亮 start tacking/end tacking and constant-stitch sewing LED not shown	按前、后倒缝键选择前加固缝和后加固缝（自动键和显示方向改变键无效） Press start and end tacking key to choose start tacking or end tacking. (Auto key and Direction key not useable)
连续回缝（花样3） bar tack sewing (Pattern 3)	按连续回缝键，指示灯亮 Press bar tack sewing, LED shown	显示屏显示E、F针的针数，按显示方向改变键显示N的趟数和G针的针数。按3~6功能键改变需设定针数 Screen shows E, F Needle number, press direction key to show N's time and G Needle's needle number. Press 3~6 function key to choose
定针缝（花样2、4） constant-stitch sewing (Pattern 2, 4)	按定针缝键，指示灯亮 Press constant-stitching sewing, LED shown	显示屏显示前、后倒缝的针数，按显示方向改变键显示N的趟数和G针的针数。按3~6功能键改变需设定针数 Press start and end tacking's needle number, press direction key to show N's time and G Needle's needle number. Use 3~6 function key to choose

### 3.3 常用参数调整详细说明

Section describes how to adjust common parameters

参数模式 Parameter Type	操作说明 Setting	功能说明 Function
进入参数区 Enter Parameter	按住↑键后开启电源 Press ↑ key and turn ON power.	显示 A1 Screen show A1
参数修改 Change Parameter	进入“A”模式后 After entering to “A” section	按+、-键，选择项次，按▷键进入（退出）选项，按+、-键修改到需要的参数值，再按E键储存 Press +, - key. Choose by ▷ to enter, then press +, - to adjust and press E key to save.
常用参数内容表 Often Used Parameter Chart		

A 組 A group	初期值 setting	設定内容 Function
1	1	1: 补针功能 Needle-up and needle-down are performed alternatel 0: 提针功能 Needle-up
2	0	1: 无定位器模式 Random stop(Use this switch when operation without synchronizer is performed) 0: 由定位器感应停止 Stop in the needle home position
3	0	1: 单讯号同步器感应模式 Needle position sensing mode(1sensor) 0: 双讯号同步器感应模式 Needle position sensing mode(2sensor)
4	0	1: A3=ON 时针上信号出力 GF519=ON(at 1sensor)Makes origin signal as needle-up 0: A3=ON 时 Z 相信号出力 GF519=ON(at 1sensor)Makes origin signal as needle-down
5	90*2=180	单信号模式时, 下针位的角度. Machine angle between standard position and needle-up at 1sensor (CW angle from origin and needle position signal input) [deg]
6	0	1: 切线中的前踩马达不运转 The sewing machine does not run after trimming 0: 切线中的前踩马达运转 The sewing machine runs after trimming
7	1	1: 后踩第一节时压脚工作 Foot lift operates at the 1st stage of heel-back 0: 后踩时第一节压脚不工作 Foot lift does not operates at the 1st stage of heel-back
8	0	1: 切线后, 自动抬压脚 AFL provided 0: 切线后, 无自动抬压脚 No AFL
9	160	自动抬脚设置(*0.1s, 间隔 5 次) Setting of automatic foot-lift (*0.1s with 5interval)
10	5*10=50	后踩第一节时压脚工作的延迟时间(*0.1S) Setting of on-delay time of foot-lift (10ms interval)
11	1*1=1	抬压脚载波 ON 時間 */Setting of on-time of chopping (ms)
12	1*1=1	抬压脚载波 OFF 時間 */Setting of off-time of chopping (ms)
14	3	3: 安全開閥信号常開状态 Safety switch mode Opened 11: 安全開閥信号常閉状态 Safety switch mode Closed
15	0	1: 踏板中立时, 无抬压脚动作 Foot-lift on with pedal neutral 0: 踏板中立时, 有抬压脚动作 Foot-lift off with pedal neutral
19	1	1: A20 设定为有效。A20 to enable 0: A20 不设定为有效 A20to disable
20	100*2=200	切线速度設定值。(以 A19 选择有效 / 无效。) Cutting speed (Use A19to choose enable/disable)
21	0	1: 切线后反转 Reversing after trimming 0: 切线后不反转 No reversing after trimming
22	1	0: 切线后反转角 20 度 Reverse angle after trimming,(20 degree) 1: 切线后反转角 30 度 Reverse angle after trimming,(30 degree) 2: 切线后反转角 45 度 Reverse angle after trimming,(45 degree) 3: 切线后反转角 60 度 Reverse angle after trimming,(60 degree) 4: 切线后反转角 75 度 Reverse angle after trimming,(75 degree) 5: 切线后反转角 90 度 Reverse angle after trimming,(90 degree) 6: 切线后反转角 105 度 Reverse angle after trimming,(105 degree)
23	0	1: 针车皮带轮 1/2 增益(大手轮)1/2 gain: Use this function when a special sewing machine vibrates at stop 0: 针车皮带轮一般增益 Normal gain: Normally, use the machine at this setting
24	1	1: 通常慢速启动 Slow start 0: 慢速启动设定为低速(依 A82-85 设定) Slow start-low speed

25	0	1:停止中轻轻刹车 Brake applied during stop 0:停止中没有刹车 No brake during stop
26	36	刹车扭力值 Brake force
27	0	1:前踩停止时针杆上停 Needle-up 0:前踩停止时针杆下停 Needle-down
28	0	1:有慢速启动 With soft start 0:无慢速启动 Without soft start
29	1	1:马达运转方向 逆时针运转 Direction of motor rotation,(Anticlockwise) 0:马达运转方向 顺时针运转 Direction of motor rotation,(Clockwise)
31	0	1:专用于菘庆立式踏板 PK-3Input Drive command and/or speed command for 12p,(9)(For Shokei PK-3) 0:用速度基座感应 Input speed command for 12p,(9)
32	0	1:第一节后踩时切线 Trimming at 1st stage heel back 0:第二节后踩时切线 Trimming at 2nd stage heel back
34	200	s/min:最低速度设定 Minimum speed adjustment
35	1500	s/min:回缝速度设定 Set the Back-Tack speed
36	0	1:底线计数器有效 The counter is Validates 0:底线计数器无效 The counter is invalid
37	2000	底线计数器的設定值 Setting the count
38	25	C1=65、66、200、202、203、205、208、214、215, T1:切线动作前延误的时间(平缝:到切线的角度) ms Delayed timing prior to timer engaged(ms)
39	70	C1=65、66、200、202、203、205、208、214、215, T2:切线 O N时间(平缝:切线 O N角度) ms Trimming time(ms)
40	25	C1=65、66、200、202、203、205、208、214、215, T3:切线 OFF~到沙拉时间 ms Delayed timing prior to tension release engaged(ms)
41	38	C1=65、66、200、202、203、205、208、214、215, T4:沙拉 O N时间 ms Timing of tension release (ms)
42	25	C1=65、66、200、202、203、205、208、214、215, T5:沙拉 OFF~到拨线的時間 ms Delayed timing prior to wiper engaged(ms)
43	70	C1=65、66、200、202、203、205、208、214、215, T6:拨线(或吹风) O N时间 ms Setting timing of wiping (ms)
44	80	C1=65、66、200、202、203、205、208、214、215, T7:拨线 OFF~到压脚的时间)ms Delayed timing prior to foot lifter engaged(ms)
46	0	1:自动倒缝各工序完成时停止 stops at the end of each process of auto-backtack 0:自动倒缝各工序完成时不停止 Does not stop at the end of each process of auto-backtack
47	100	A46 的停止時間 0~510[ms] setting of stop time of GF116 0 ~ 510[ms] (2ms interval)
48	1	1:轻触踏板, 完成前倒缝动作 Ends the start-backtack by inching-pedal down 0:受踏板控制, 任意停止 No ending of start -backtack by inching-pedal down
49	1	1:电源 ON 後自动找上定位 Validates needle-up after power-on 0:电源 ON 後无自动找上定位 Invalidates needle-up after power-on
50	0	1:停止中倒缝开关無效 Invalidates manual backtack during stopping 0:停止中倒缝开关有效 Validates manual backtack during stopping
53	1	1 :始缝无布启动, 有布开始计数 Edge sensor activate even without fabric, needle count enable as well 0 :始缝无布不启动 Edge sensor inactivate without fabric
54	1	1:选针盒不接则无 ABT Disconnecting console without ABT 0:选针盒不接也有 ABT Disconnecting console with ABT



55	1	1: 设置最大外部速度到 2 倍速度 Sets max. and external speed to double 0:设置最大外部速度到下常速度 sets max.and external speed to normal
56	0	1:后倒缝个别速度一一 A57 可调整 Backtack speed adjusting A57 to adjust 0:前倒缝, 后倒缝同速度 SBT and EBT speed are the same
57	1900	后倒缝速度值 (A56=1) Backtack speed(A56=1)
66	0	1:每次前踩有慢速启动 Validates soft-start by every pecal-down 0:无 每次前踩有慢速启动 Validates soft-start only after trimming
67	1	1:倒缝线圈电压有载波 Chopping of back tack solenoid 0:倒缝线圈电压无载波 No chopping of back tack solenoid
69	0	1:自动倒缝时的针数+10 针(ABCD 针数各加 1 0 针)Add +10 stitches of setting for automatic back tack 0:自动倒缝时的针数依选针盒设定 No Addition of +10 stitches of setting for automatic back tack
70	180	针车最高速度限制 MAX speed setting
72	0	1:不在定位点时, 后踏有找上停动作 Not in the anchor point, the back step has to find the stop action 0:不在定位点时, 后踏无动作 Not at the anchor point, the back step has no action
73	0	前倒缝吸合的时间延迟 Time delay of the front inverted seam suction
74	0	前倒缝放开的时间延迟 Time delay in opening the front reverse seam
75	0	后倒缝吸合的时间延迟 Time delay of back seam suction
76	0	后倒缝吸合的时间延迟 Time delay of back seam suction
77	0	前倒缝针数補正 (A) Correction of inverted front stitches (A) 0:0 needle
78	0	前倒缝针数補正 (B) Correction of inverted front stitches (B) 1:+1 needle
79	0	后倒缝针数補正 (C) Correction of inverted front stitches (C) 2:+2 needle
80	0	后倒缝针数補正 (D) Correction of inverted front stitches (D) 3:-1 needle 4: -2 needle
82	20 * 20	第一针缝制速度(A24=0 时) First Needle Speed (A24=0)
83	32 * 20	第二针缝制速度(A24=0 时) Second Needle Speed (A24=0)
84	50 * 20	第三针缝制速度(A24=0 时) Third Needle Speed (A24=0)
85	85 * 20	第四针缝制速度(A24=0 时) Fourth Needle Speed (A24=0)
91	0	1:抬压脚汽阀式专用(输出电压 DC24V) FL Air Pneumatic Type (DC 24V) 0: 抬压脚电磁铁专用 FL Solenoid Type
92	1	1:后踩第二节时压脚工作 Activates foot-lift with 2rc.stage heel-back 0:后踩时第二节压脚不工作 Deactivates foot-lift with 2rc. stage heel-back
93	0	1:选针盒的测试模式 Select the test mode of the needle box 0:正常工作模式 Normal operating mode 11-99:自动测试模式(个位停止时间, 十位运转时间) Automatic test mode (one stop time, ten run time)
94	100,125	负载惯性作为加速度数据设定 Load inertia (setting as accelerating data)
95	1	1:前踩 4 针时, 后踩有后倒缝动作 the front step 4 stitches, the back step has the backward stitch action 0:前踩一针时, 后踩有后倒缝动作 the front step a stitch, the back step has the back stitch action
98	0	1:后踏有刹车动作 Rear step has braking action 0:后踏无刹车动作 No braking action on the rear step
101		C1=100、104、105、120、124、125, 前吸风的针数 1 <sup>st</sup> half vacuum needle count
102		C1=101、121, 后吸风的针数 2 <sup>nd</sup> half vacuum needle count

103		GW 慢速时的速度调整 GWS Slow speed adjusting
104		C1=13、18、510, 沙拉线圈动作对切线圈动作的延时时间 Delayed timing prior to tension release enable
105		C1=13、18、510, 沙拉线圈动作比切线圈动作延时结束时间 Delayed timing prior to tension release disable
106		C1=103、106、107、108、123、126、127、128, 节气功能 C1 的针数 C1 needle count
107		C1=103、106、107、108、123、126、127、128, 节气功能 C2 的针数 C2 needle count
108		C1=103、107、123、127, 节气功能 C3 的针数, C3 needle count
109	2500	C1=606、607, KN-OUT 的输出时间 KN-OUT output time
110	1000	C1=606、607, HLT-OUT 比 KN-OUT 的延时时间 HLT-OUT than KN-OUT delay time
111	2500	C1=606、607, HLT-OUT 的输出时间 HLT-OUT output time
112	200	C1=606、607, 下一次按键有效的延时时间 The next key valid delay time
113	800	C1=606、607, 针车停止时延时吸风时间 Sewing stop suction when the delay time
114	2	C1=201、206、209, 三本车 WIP 吸风时间*512ms Three vehicle suction time WIP*512ms
115	180	C1=201、206、209, 三本车 WIP 吸风时间*2ms Three car WIP suction time * 2ms
116	3000	C1=512, 微动型开关第一段速度调整 mini switch 1st section speed adjusting
117	2500	C1=512, 微动型开关第二段速度调整 mini switch 2nd section speed adjusting
118	2000	C1=512, 微动型开关第三段速度调整 mini switch 3rd section speed adjusting
119	1500	C1=512, 微动型开关第四段速度调整 mini switch 4th section speed adjusting
120	200	C1=108、128, 剃布线圈动作时间 cutting solenoid time
121	200	C1=108、128, 第二次剃布线圈动作的等待时间 second cutting solenoid time delay
122	20	C1=107、127, 节气功能 C4 的针数 C4 needle count
123	20	C1=107、127, 节气功能 C5 的针数 C5 needle count
124	20	C1=107、127, 节气功能 C6 的针数 C6 needle count
125	2	C1=201、206、209, 三本车 WIP 吹风时间*512ms Chain stitch WIP blow time*512ms
126	1	1:拨线线圈 ON Wiper Solenoid ON 0:拨线线圈 OFF Wiper Solenoid OFF
127	2	C1=211、212、213, 绷缝车锁线设定针数 chainstitch lock needle setting
128	0	C1=211、212、213, 绷缝车上停开始锁线的角度 chainstitch needle up angle
129	180	C1=211、212、213, 绷缝车锁线线圈动作的时间 chainstitch coil time
130	0	1:夹线功能有效 (ON) Grasp thread (ON) 0:夹线功能无效 (OFF) Grasp thread (OFF)
131	70	上停到夹线动作 C1 的延时角度 Needle up to grasp thread C1 delay angle
132	100	夹线动作 C2 时间 (角度) Grasp thread C2 time (angle)

### 3.4 F参数调整详细说明

#### F Parameter Adjustment Details

参数模式 Parameter Type	操作说明 Setting	功能说明 Function
进入参数区 Enter Parameter	开启电源, 同时按住 E 键和 - 键 Power on and hold down the E and - keys at the same time	显示 F001 Screen show F001

F 组	初期值	设定内容
GF18	5	开关触发值 Finger Switch IN
GF19	7	A14
GF38	15	机器运行信号从 AUX1 输出 Machine Run Signal OUT from AUX1

<b>GF39</b>	<b>0</b>	
<b>GF40</b>	<b>15</b>	MT 切断信号从 AUX2 输出 MT Cutter OUT from AUX2
<b>GF41</b>	<b>6</b>	
<b>GF46</b>	<b>15</b>	自动速度输出 Auto Speed OUT
<b>GF47</b>	<b>15</b>	
<b>GF102</b>	<b>1</b>	初级系列 (A96) First born series no.
<b>GF106</b>	<b>57</b>	切线指定 Thread cut queue appoint
		16: 默认值 T_AN
		17: 电机转半圈 half round of motor back
		18: A2
		19: T_Y1_PP
		56-57: 可编项目 Programable items
		100: 计数切带禁用 counter thread cut sequence disable
<b>GF107</b>	<b>4</b>	模式 1 开始 BT 缝设置(A) Pattern 1 start BT stich setup(A)
<b>GF108</b>	<b>4</b>	模式 1 开始 BT 缝设置(B) Pattern 1 start BT stich setup(B)
<b>GF109</b>	<b>4</b>	模式 1 开始 BT 缝设置(C) Pattern 1 start BT stich setup(C)
<b>GF110</b>	<b>4</b>	模式 1 开始 BT 缝设置(D) Pattern 1 start BT stich setup(D)
<b>GF111</b>	<b>2</b>	模式 1 启动 BT none(2)/1 对/2 对(0)/4 对(3) Model 1 start BT none(2)/1couple/2couples(0)/4couples(3)
<b>GF112</b>	<b>2</b>	模式 1 启动 BT none(2)/1 对/2 对(0)/4 对(3) Model 1 start BT none(2)/1couple/2couples(0)/4couples(3)
<b>GF113</b>	<b>81</b>	垂足曲线 Pedal curve
<b>GF114</b>	<b>1</b>	ON:检查倒车驱动器→断线过程中假针下降情况 OFF:检查倒车→断线过程中针边下降情况 ON : check the fake stitch decline situation during it backing to driver → thread cut OFF:check the decline of stitch edge during it backing→thread cut
<b>GF115</b>	<b>0</b>	ON:将 GF132 限速设置为(大于)800[s/min], 将 GF132 限速设置为 400[s/min]ON:set the speed limit of GF132 as(more than)800[s/min],set the speed limit GF132 as 400[s/min]
<b>GF116</b>	<b>0</b>	ON:自动转 BT 每端停止 OFF:自动转 BT 每端不停止 ON:stop at the every end of auto BT OFF:non-stop at the every end of auto BT(A46)
<b>GF117</b>	<b>50</b>	GF116 停止时间(单位:[ms])GF116 stopping time(unit:[ms])(A47)
<b>GF118</b>	<b>1</b>	N:步进踏板反应 BT OFF:关闭 1 次步进踏板反应 BT ON:step pedal react BT OFF:disable 1 time step pedal react BT (A48)
<b>GF119</b>	<b>15</b>	模式 3 BT 电磁阀连接延时(单位[ms])React BT. Pattern 3 BT solenoid valve connecting time delay(unit[ms]) (A73)
<b>GF120</b>	<b>15</b>	BT.模式 3 BT 电磁体设置延时关闭时间(单位[ms])React BT. Pattern 3 BT electric magnet setup delay time off(unit[ms]) (A74)
<b>GF121</b>	<b>15</b>	电磁铁设置延时时间(单位[ms])Shut off BT BTelectric magnet setup delay time(unit[ms])
<b>GF122</b>	<b>15</b>	电磁铁关闭设置关闭时间[单位[毫秒]]Shut off BT BTelectic magnet shut down setup delay time[unit[ms]]
<b>GF123</b>	<b>1</b>	亮灯:高速软启动(400、650、1000、1700 spm)灭灯:高速软启动(POS、POS、400、600 spm)Light-on:high speed soft start(400,650,1000,1700 spm)light-off:high speed soft start(POS,POS,400,600 spm) (A24)
<b>GF124</b>	<b>1</b>	ON:单头 BT 完成后开始单针直缝;OFF:单头 BT 完成后不开始单针直缝 ON :single needle straight sewing start after single end BT finish;OFF:single needlr straight sewing wont start after single
<b>GF125</b>	<b>1</b>	ON:电磁铁在断线前打开, 断线时 BT 连接;OFF:断线时断开 ON:BT connecting when thread cut if electric magnet open before thread cut;OFF:disconnected when thread cut

<b>GF126</b>	<b>1</b>	ON:底部左测;未检测到剩余的底部线程 ON:bottom thread left detect bottom; undetect bottom thread left
<b>GF127</b>	<b>0</b>	ON:每步软启动;OFF:切线后软启动 ON:every time step soft start;OFF:start only after soft start of thread cut(A66)
<b>GF128</b>	<b>0</b>	ON:紧急切断 BT 开关;OFF:紧急切断 BT 开关 ON:emergency thread cut BT off;OFF:emergency thread cut and BT on
<b>GF130</b>	<b>0</b>	ON:软启动时关闭;OFF:非软启动 ON:OFF when soft start;OFF:non-soft start(A28)
<b>GF131</b>	<b>0</b>	ON:CCW 旋转命令;OFF:CW 旋转命令(A29) ON:CCW Rotate command; OFF:CW Rotate command
<b>GF132</b>	<b>50</b>	切线速度, 脚踏板的最小速度, 位置速度设置(单位[ms])Thread cut speed,min-speed of pedal stepped,position speed setup(unit[ms]) (A34)
<b>GF133</b>	<b>95</b>	GF195= 开机后结束 BT 速度(单位[s/min]) GF195=end up BT speed since ON(unit[s/min])(A57)
<b>GF134</b>	<b>95</b>	起停速度 Start & End BT Speed(A35)
<b>GF135</b>	<b>200</b>	电机最高转速转换速度(单位[r/min])MAX. Speed of motor conversion(unit[r/min]) (A97)
<b>GF136</b>	<b>227</b>	电机外转速(工作单位(r/min))Motor outside speed(serve unit(r/min))
<b>GF137</b>	<b>0</b>	ON: 当“SAFETY”发生时, 可通过 P-I/O 低速开关 (mov_p) 进行驱动。OFF: 当“SAFETY”发生时, 不能驱动 ON : when “ SAFETY”occured, could drive by P-I/O low speed switch (mov_p) OFF : when “ SAFETY”occured, cant drive
<b>GF139</b>	<b>1</b>	ON: BT 启动完成后软启动 OFF: BT 启动完成后软启动 ON soft start on after BT start finish OFF : soft start disable after BT start finish
<b>GF144</b>	<b>1</b>	ON:当 GF163 打开时, 前切线开始前停止。OFF:当 GF163 打开时, 前切线不停止 ON : stop before thread cut start when GF163 open OFF : non-stop before thread cut start when GF163 open
<b>GF145</b>	<b>120</b>	常值:踏板电压为 R1 时的设置速度(单位[r / min])constant : setup speed when pedal voltage as R1 (unit[r / min])
<b>GF146</b>	<b>20</b>	常值:踏板设置倾斜数据 1(0-R1)constant : pedal setup tilt data 1 (0-R1)
<b>GF147</b>	<b>35</b>	常值:踏板倾斜角度数据(R1-R2)constant : pedal tilt angle data (R1-R2)
<b>GF148</b>	<b>87</b>	常值:踏板倾斜角度数据(R2-100%)constant : pedal tilt angle data3 (R2-100%)
<b>GF149</b>	<b>153</b>	恒值:踏板电压 R1eternal : pedal voltage R1
<b>GF150</b>	<b>108</b>	常值:电压下降 2 步检测位置(用于检测 PD2 的传输 A / D 值)constant : voltage decline 2 step detect position (for detecting the convey A / D value of PD2)
<b>GF151</b>	<b>60</b>	常值: 退步检测位置(用于检测 PU1 的输出 A / D 值)constant : step backward detect position (for detecting the convey A / D value of PU1)
<b>GF152</b>	<b>22</b>	常值:后退检测位置(用于检测 PU2 的输出 A / D 值)constant double step backward detect position (for detecting the convey A / D value of PU2)
<b>GF153</b>	<b>0</b>	ON:激活数值 MAX 以设置 SW1 / 2 正常进料 OFF: SW 以下禁用 ON : activate number value MAX to set SW1 / 2 for normal feed OFF : disable below SW。
<b>GF154</b>	<b>1</b>	ON:电刷正极驱动 OFF:电刷负极驱动 ON : Wiper electric drive positive OFF : Wiper electric drive negative
<b>GF155</b>	<b>1</b>	ON:切线正极驱动 OFF:切线负极驱动 ON :thread cut electric drive positive OFF :thread cut electric drive negative
<b>GF156</b>	<b>0</b>	ON:踏板信号输入转移到最大速度命令的过程 OFF:踏板信号输入使用正常的步进踏板命令的过程 ON :pedal signal input transfer to MAX speed command and process OFF :pedal signal input use as normal stepping pedal command and process
<b>GF158</b>	<b>0</b>	ON:切线时踩踏板, 电机未运行 OFF:切线时踩踏板, 电机运行 ON : step pedal during thread cut, motor not running OFF : step pedal during thread cut, motor running
<b>GF159</b>	<b>1</b>	亮: 电磁阀起。灭:无电磁阀 light-on :Solenoid valve chopping exist light-off :non-Solenoid valve chopping

<b>GF160</b>	<b>0</b>	ON:GF135 正极 OFF:GF135 负极 ON : GF135 positive OFF : GF135 negative
<b>GF161</b>	<b>1</b>	ON:断电后软启动。OFF:断电后非软启动 ON :soft start after power come Off :non-soft start after power come
<b>GF162</b>	<b>1</b>	ON:上电时自动起针。OFF:上电时不起针 ON : auto needle up when power on Off : needle wont up when power on
<b>GF163</b>	<b>0</b>	ON:上针切线 OFF:下针切线 ON :thread cut Logic form needle top OFF :thread cut Logic form needle bottom
<b>GF164</b>	<b>1</b>	ON:停止时禁止 MBT。OFF:停止时激活 MBT ON : forbid MBTwhen stop OFF : active MBT when stop
<b>GF165</b>	<b>30</b>	ON:当半缝 SW 时自动起针, OFF: 当半缝 SW 时手动起针 ON : with half stitch SW to lift up needle off : with half stitch SW mannual sewing machine lift up needle。
<b>GF166</b>	<b>1</b>	手动 SW ON / PU2 抬脚时间(单位[100ms])manual FLSW ON / PU2 foot lifter up time (unit[100ms])
<b>GF167</b>	<b>1</b>	ON:单次停止 OFF:位置速度停止 ON: single time to stop Stop : serve speed OFF : position speed stop
<b>GF168</b>	<b>1</b>	ON:普通类型 SPEION OFF:大和 SAS 类型 ON :normal type SPEION off :YAMATO SAS type
<b>GF169</b>	<b>1</b>	ON:(当 GF168 = ON 时)检测织物前不会启动 OFF:检测织物前启动, 检测后计数 ON : (when GF168 = ON) wont start before detect fabric OFF : start before detect fabric, count after detect
<b>GF170</b>	<b>0</b>	设为 0 时, 在 GF402 项加 10 针 If GF170=0, 10 stitches is plussed on GF402
<b>GF171</b>	<b>0</b>	ON: GF175 ~ GF177 软启动 OFF: GF123 软启动 ON :follow GF175 to GF177 start with soft start speed OFF : follow GF123 start with soft start speed
<b>GF175</b>	<b>20</b>	软启动第一针速度:单位[s / min]first stitch speed of soft start : unit[s / min]
<b>GF176</b>	<b>32</b>	启动第二针速度:单位[s / min]second stitch speed of soft start (unit : [s / min])
<b>GF177</b>	<b>50</b>	启动第三针速度:单位[s / min]third stitch speed of soft start (unit : [s / min])
<b>GF178</b>	<b>85</b>	启动第四针速度:单位[s / min]fourth stitch speed of soft start (unit[s / min])
<b>GF179</b>	<b>0</b>	0: 标准类型; 1:DINO 类型; 2:速度显示 0 : standard type display1 : DINO type display2 : speed display
<b>GF180</b>	<b>0</b>	ON: E / F / G 设置结束为图案 2,3,4 的-1 针。OFF:为正常型 ON :the end of E / F / G setup as -1 stitch of pattern 2、 3 and 4 OFF : provide normal type for normal。
<b>GF181</b>	<b>0</b>	停机速度随机 random drive/stop input driving speed
<b>GF182</b>	<b>0</b>	访问参数保存值 L visit parameter save value L
<b>GF183</b>	<b>0</b>	访问参数保存值 H visit parameter save value H
<b>GF184</b>	<b>0</b>	ON:停止速度在位置 1, OFF: 停止速度在位置 2 ON :1 position stop SPEED。OFF :2 position stop SPEED。
<b>GF185</b>	<b>10</b>	设置检测图案 1 侧缝 set detect pattern 1 side stitches
<b>GF186</b>	<b>0</b>	ON:踏板速度先于踏板速度的外部速度, OFF:受外部速度限制的踏板速度 ON : pedal speed and outside speed in advance of pedal speed , OFF : pedal speed and outside speed limited by outside speed
<b>GF187</b>	<b>0</b>	ON:光学传感器 B 时间设置部分:GF414,1 刀作用时间:使用 GF419 设置, OFF:光学传感器 B 时间设置部分:GF425,1 刀作用时间:GF427 ON : Optics sensor B time setup part : GF414, 1 cutter acting time : use GF419 to set OFF : Optics sensor B time setup part : GF425, 1cutter acting time : GF427
<b>GF188</b>	<b>0</b>	ON: B 传感器无延时启动; OFF: B 传感器延时 ON :Optics sensor B start without delay OFF : Optics sensor B delay positive
<b>GF189</b>	<b>0</b>	0 : 普通型, 10 : SEQ_1 ,11 : SEQ_2, 12 : SEQ_3, 13 : 切线, 14 : SEQ_4, 15: SEQ_5 ,16: SEQ_6, 17: 30.4 双倍缝 0 : normal type, 10 : SEQ_1 ,11 : SEQ_2, 12 : SEQ_3, 13 : thread cut, 14 : SEQ_4, 15: SEQ_5 ,16: SEQ_6, 17: 30.4 double sew
<b>GF191</b>	<b>0</b>	ON:当自动转 BT 时间停止时仍转 BT, OFF:当自动转 BT 时间停止时转 BT 关闭 ON :BT on



		even when auto BT time stop OFF : BT close when auto BT time stop
<b>GF192</b>	<b>0</b>	ON:掉针前立即停止 OFF:掉针前不停机 ON : stop right away before needle drop OFF : non-stop before needle drop
<b>GF193</b>	<b>1</b>	ON:设置最大/扩展速率为双倍 OFF:设置最大/扩展速率为正常 ON : Set MAX / EXT speed double OFF : set MAX / EXTspeed normal
<b>GF195</b>	<b>0</b>	ON: GF133 只能设定的 EBT 速度, OFF:GF134 可设定 EBT 速度 ON : EBT speed set by GF133 only OFF : EBT set by GF134
<b>GF196</b>	<b>1</b>	ON: 只能 GF197 规定的切线时间 OFF: GF132 规定的切线时间 ON : cutting time set by GF197only OFF : cutting time set byGF132
<b>GF197</b>	<b>100</b>	切线速度值(根据 GF196 正负选择) value of thread cut speed (choose by GF196 positive/negative)
<b>GF198</b>	<b>1</b>	选择的复位序列 the reset series of being chosen
<b>GF201</b>	<b>4</b>	开始 BT 直缝量设置 start BT straight stitches amount setup
<b>GF202</b>	<b>4</b>	开始 BT 直缝后设置 start BT straight back stitches amount setup
<b>GF203</b>	<b>4</b>	结束 BT 直缝量设置 End BT straight back stitches amount setup
<b>GF204</b>	<b>4</b>	结束 BT 直缝后设置 End BT straight stitches amount setup
<b>GF205</b>	<b>0</b>	模式 2: 2-没有 BT 开始, 1-1 倍, 0-2 倍, 3-4 倍 model 2 start without BTnone (2) / 1couple (1) / 2couples (0) / 4couples (3)
<b>GF206</b>	<b>0</b>	模式 2: 2-没有 BT 结束, 1-1 倍, 0-2 倍, 3-4 倍 model 2 end BTnone (2) / 1couple (1) / 2couple (0) / 4couple (3)
<b>GF207</b>	<b>20</b>	模式 2: 定形针(G) pattern 2 setting stitches (G)
<b>GF208</b>	<b>255</b>	模式 2: 缝纫速度(单位[s / min])pattern 2 sewing speed (serve unit (unit[s / min]))
<b>GF209</b>	<b>0</b>	ON:单次使用 GF208 固定速度(自动), OFF:用踏板控制速度 ON :work at single time with GF208to fix speed (AUTO) OFF : with pedal control speed
<b>GF210</b>	<b>0</b>	ON:计数模式 2 设置针数, 停止:结束 BT 和切断线后, 模式 2 针数完 ON :count the pattern 2 setup stitches and stop : end BT and thread cut after pattern 2 stitches finish counting
<b>GF211</b>	<b>0</b>	亮:自动(当 GF210 停止时) 灭:无自动 light on : auto FL exist (when GF210 stop) light off : none auto FL
<b>GF301</b>	<b>5</b>	在模式 3 设置针数开始缝 (E) setup stitches at the pattern 3 start to sew (E)
<b>GF302</b>	<b>10</b>	模式 3 的后缝设置 (F) pattern 3 (F) sew-back stitches setup
<b>GF303</b>	<b>10</b>	模式 2 设置后的标准针线(G)standard stitches after set pattern2 (G)
<b>GF304</b>	<b>3</b>	E,F,G 重复时间(n) E, F, G repeat time (n)
<b>GF307</b>	<b>255</b>	模式 3 的缝制速度(单位[s / min])sewing speed of sewing pattern 3 (unit[s / min])
<b>GF308</b>	<b>1</b>	ON:单次使用 GF307 固定速度(自动)OFF:用踏板控制速度 ON : work at single time with GF307 to fix speed (AUTO) OFF : with pedal control speed
<b>GF401</b>	<b>4</b>	模式 4 开始 BT 缝设置(A)pattern 4 start BT stitch setup (A)
<b>GF402</b>	<b>4</b>	模式 4 开始 BT 反针设置(B)pattern 4 start BT counter stitch setup (B)
<b>GF403</b>	<b>4</b>	模式 4 端 BT 反针设置(C)pattern 4 end BT counter stitch setup (C)
<b>GF405</b>	<b>4</b>	模式 4 端 BT 直缝设置(D)pattern 4 end BT straight stitch setup (D)
<b>GF406</b>	<b>0</b>	模式 4: 2-无 BT 开始; 1-两对; 0-2 对; 3-4 对。 model 4 start BT none (2) / 1couple (1) / 2couples (0) / 4couples (3)
<b>GF409</b>	<b>1</b>	ON:单拍固定速度(自动)OFF:脚踏设定速度 ON : single shoot with fixed speed (AUTO) OFF : pedal set the speed
<b>GF411</b>	<b>10</b>	停机数针 Stitch number for machine Stop at end
<b>GF412</b>	<b>10</b>	延时针数 Stitch number for next process
<b>GF413</b>	<b>10</b>	模式 4 第一次加工针迹设置(G1)pattern 4 first process stitch setup (G1)
<b>GF414</b>	<b>10</b>	模式 4 第二次加工针迹设置(G2)pattern 4 second process stitch setup (G2)
<b>GF415</b>	<b>10</b>	模式 4 第三次加工针迹设置(G3)pattern 4 third process stitch setup (G3)



<b>GF416</b>	<b>10</b>	模式 4 第四次加工针迹设置(G4)pattern 4 fourth process stitch setup (G4)
<b>GF417</b>	<b>10</b>	模式 4 第五次加工针迹设置(G5)pattern 4 fifth process stitch setup (G5)
<b>GF418</b>	<b>10</b>	模式 4 第六次加工针迹设置(G6)pattern 4 sixth process stitch setup (G6)
<b>GF419</b>	<b>10</b>	模式 4 第七次加工针迹设置(G7)pattern 4 seventh process stitch setup (G7)
<b>GF425</b>	<b>0</b>	电眼 1 延时时间 optics sensor 1 delay time (A58)
<b>GF427</b>	<b>0</b>	切线时间 cutter activate time
<b>GF431</b>	<b>255</b>	G1 缝速(单位[s / min])G1 sewing speed (unit[s / min])
<b>GF432</b>	<b>255</b>	G2 缝速(单位[s / min])G2 sewing speed (unit[s / min])
<b>GF433</b>	<b>255</b>	G3 缝速(单位[s / min])G3 sewing speed (unit[s / min])
<b>GF434</b>	<b>255</b>	G4 缝速(单位[s / min])G4 sewing speed (unit[s / min])
<b>GF435</b>	<b>255</b>	G5 缝速(单位[s / min])G5 sewing speed (unit[s / min])
<b>GF436</b>	<b>255</b>	G6 缝速(单位[s / min])G6 sewing speed (unit[s / min])
<b>GF437</b>	<b>255</b>	G7 缝速(单位[s / min])G7 sewing speed (unit[s / min])
<b>GF438</b>	<b>255</b>	G8 缝速(单位[s / min])G8 sewing speed (unit[s / min])
<b>GF439</b>	<b>255</b>	G9 缝速(单位[s / min])G9 sewing speed (unit[s / min])
<b>GF440</b>	<b>140</b>	现在不使用 not use now
<b>GF441</b>	<b>0</b>	ON:G1 面料检测存在 OFF:非 G1 面料检测 ON : G1fabric detect exist OFF : non-G1fabric detect 。
<b>GF442</b>	<b>0</b>	ON:G2 面料检测存在 OFF:非 G2 面料检测 ON : G2fabric detect exist OFF : non-G2fabric detect 。
<b>GF443</b>	<b>0</b>	ON:G3 面料检测存在 OFF:非 G3 面料检测 ON : G3fabric detect exist OFF : non-G3fabric detect 。
<b>GF444</b>	<b>0</b>	ON:G4 面料检测存在 OFF:非 G4 面料检测 ON : G4fabric detect exist OFF : non-G4fabric detect 。
<b>GF445</b>	<b>0</b>	ON:G5 面料检测存在 OFF:非 G5 面料检测 ON : G5fabric detect exist OFF : non-G5fabric detect 。
<b>GF446</b>	<b>0</b>	ON:G6 面料检测存在 OFF:非 G6 面料检测 ON : G6fabric detect exist OFF : non-G6fabric detect 。
<b>GF447</b>	<b>0</b>	ON:G7 面料检测存在 OFF:非 G7 面料检测 ON : G7fabric detect exist OFF : non-G7fabric detect 。
<b>GF448</b>	<b>0</b>	ON:G8 面料检测存在 OFF:非 G8 面料检测 ON : G8fabric detect exist OFF : non-G8fabric detect 。
<b>GF449</b>	<b>0</b>	ON:G9 面料检测存在 OFF:非 G9 面料检测 ON : G9fabric detect exist OFF : non-G9fabric detect 。
<b>GF450</b>	<b>0</b>	现在不使用 not use now
<b>GF451</b>	<b>1</b>	ON:G1 缝制完后停止 OFF:G1 缝制完后不停机 ON : stop after finish G1 sewing OFF : non-stop after finish G1 sewing
<b>GF452</b>	<b>1</b>	ON:G2 缝制完后停止 OFF:G2 缝制完后不停机 ON : stop after finish G2sewing OFF : non-stop after finish G2sewing
<b>GF453</b>	<b>1</b>	ON:G3 缝制完后停止 OFF:G3 缝制完后不停机 ON : stop after finish G3sewing OFF : non-stop after finish G3sewing
<b>GF454</b>	<b>1</b>	ON:G4 缝制完后停止 OFF:G4 缝制完后不停机 ON : stop after finish G4sewing OFF : non-stop after finish G4sewing
<b>GF455</b>	<b>1</b>	ON:G5 缝制完后停止 OFF:G5 缝制完后不停机 ON : stop after finish G5sewing OFF : non-stop after finish G5sewing
<b>GF456</b>	<b>1</b>	ON:G6 缝制完后停止 OFF:G6 缝制完后不停机 ON : stop after finish G6sewing OFF : non-stop after finish G6sewing
<b>GF457</b>	<b>1</b>	ON:G7 缝制完后停止 OFF:G7 缝制完后不停机 ON : stop after finish G7sewing OFF :

		non-stop after finish G7sewing
<b>GF458</b>	<b>1</b>	ON:G8 缝制完后停止 OFF:G8 缝制完后不停机 ON : stop after finish G8sewing OFF : non-stop after finish G8sewing
<b>GF459</b>	<b>1</b>	ON:G9 缝制完后停止 OFF:G9 缝制完后不停机 ON : stop after finish G9sewing OFF : non-stop after finish G9sewing
<b>GF460</b>	<b>1</b>	现在不使用 not use now
<b>GF461</b>	<b>1</b>	ON: G1 后自动压脚 OFF: G1 后不自动压脚 ON : auto FL after G1。 OFF : non-auto FL after G1
<b>GF462</b>	<b>1</b>	ON: G2 后自动压脚 OFF: G2 后不自动压脚 ON : auto FL after G2。 OFF : non-auto FL after G2
<b>GF463</b>	<b>1</b>	ON: G3 后自动压脚 OFF: G3 后不自动压脚 ON : auto FL after G3。 OFF : non-auto FL after G3
<b>GF464</b>	<b>1</b>	ON: G4 后自动压脚 OFF: G4 后不自动压脚 ON : auto FL after G4。 OFF : non-auto FL after G4
<b>GF465</b>	<b>1</b>	ON: G5 后自动压脚 OFF: G5 后不自动压脚 ON : auto FL after G5。 OFF : non-auto FL after G5
<b>GF466</b>	<b>1</b>	ON: G6 后自动压脚 OFF: G6 后不自动压脚 ON : auto FL after G6。 OFF : non-auto FL after G6
<b>GF467</b>	<b>1</b>	ON: G7 后自动压脚 OFF: G7 后不自动压脚 ON : auto FL after G7。 OFF : non-auto FL after G7
<b>GF468</b>	<b>1</b>	ON: G8 后自动压脚 OFF: G8 后不自动压脚 ON : auto FL after G8。 OFF : non-auto FL after G8
<b>GF469</b>	<b>1</b>	ON: G9 后自动压脚 OFF: G9 后不自动压脚 ON : auto FL after G9。 OFF : non-auto FL after G9
<b>GF470</b>	<b>1</b>	现在不使用 not use now
<b>GF471</b>	<b>0</b>	ON:G1 作为反缝 OFF:G1 作为正常缝 ON : G1 as opposite sew OFF : G1 as normal sewing
<b>GF472</b>	<b>0</b>	ON:G2 作为反缝 OFF:G2 作为正常缝 ON : G2as opposite sew OFF : G2 as normal sewing
<b>GF473</b>	<b>0</b>	ON:G3 作为反缝 OFF:G3 作为正常缝 ON : G3as opposite sew OFF : G3 as normal sewing
<b>GF474</b>	<b>0</b>	ON:G4 作为反缝 OFF:G4 作为正常缝 ON : G4as opposite sew OFF : G4 as normal sewing
<b>GF475</b>	<b>0</b>	ON:G5 作为反缝 OFF:G5 作为正常缝 ON : G5as opposite sew OFF : G5 as normal sewing
<b>GF476</b>	<b>0</b>	ON:G6 作为反缝 OFF:G6 作为正常缝 ON : G6as opposite sew OFF : G6 as normal sewing
<b>GF477</b>	<b>0</b>	ON:G7 作为反缝 OFF:G7 作为正常缝 ON : G7as opposite sew OFF : G7 as normal sewing
<b>GF478</b>	<b>0</b>	ON:G8 作为反缝 OFF:G8 作为正常缝 ON : G8as opposite sew OFF : G8 as normal sewing
<b>GF479</b>	<b>0</b>	ON:G9 作为反缝 OFF:G9 作为正常缝 ON : G9as opposite sew OFF : G9 as normal sewing
<b>GF480</b>	<b>0</b>	现在不使用 not use now
<b>GF481</b>	<b>1</b>	ON:数完 4 针后停止 OFF:数完 4 针后 BT 停止切线动作 ON :4 stitches after counting then stop OFF : 4 stitches after counting then BT stop and thread cut act.
<b>GF482</b>	<b>0</b>	ON:延迟 GF483 启动时间, 延迟花样启动时间(踩踏板除外)OFF:花样 4 动作不会延迟 GF483 动作时间 ON : delay the time of GF483 starting time to delay the starting time of Pattern (except stepping pedal )OFF : Pattern 4 act would not delay the time of GF483 acting time
<b>GF483</b>	<b>5</b>	GF482 = ON 时的启动延迟时间(单位:[100ms])start delay time when GF482 = ON (unit : [100ms])
<b>GF484</b>	<b>1</b>	ON:手动缝 BT 工作 OFF:手动缝无 BT 工作 ON :manual sewing BT work OFF :manual sewing without BT
<b>GF485</b>	<b>0</b>	ON : set GF421 to GF430 as P4_AUX1,2 output data : 0 : P4_AUX1,2 off, 1 : P4_AUX1on, 2 : P4_AUX2 on, 3 : P4_AUX1,2 on
<b>GF486</b>	<b>0</b>	ON:将 GF411 到 GF419 设置双倍针数为 GF419 OFF:GF411 到 GF419 针数不变 ON : set the double stitches setting of GF411to GF419OFF : GF411 to GF419 stitches no change

<b>GF487</b>	<b>0</b>	ON: 当 GF481 = ON 时, 踏板停止电机运行 ON : when GF481 = ON negative, pedal stop motor run (A87)
<b>GF501</b>	<b>60</b>	缝线角度从 MC 针前侧到防护装置旋转方向(单位:0.25 度) the sewing angle from mc needle front to guard command rotate direction (unit : 0.25degree)
<b>GF502</b>	<b>1</b>	灯亮: 带轮比存在 light on : Pulley ratio learning exist 灯灭: 带轮比不存在 light off : Pulley ratio learning not exist
<b>GF503</b>	<b>1</b>	ON:找上针位置(存在 2 个传感器), Off:不找上针位置 ON : learning needle up position (exist with 2 sensor) , Off : not learn needle up position
<b>GF505</b>	<b>160</b>	针的宽度的缝纫角度(单位[0.25 度]the sewing angle of the needle position signal width (unit[0.25degree]).
<b>GF506</b>	<b>160</b>	编码器针点之间的脉冲量(低段)the quantity of pulse of encoder between needle point (low byte)
<b>GF507</b>	<b>5</b>	编码器针点之间的脉冲量(高段)the quantity of pulse of encode between needle point (high byte)
<b>GF508</b>	<b>70</b>	设置好线扣规格模式后, 线扣 SOL 为 ON。与针极角 C1 有关。如果值是“下限限值”等, 使针极移动, 捕线器 SOL 将立即打开 after setting up the mode of thread catch specification, thread catch SOL turn to ON。relate to needle pole angle C1。if value are“low limit value” etc, so that needle pole move, thread catcher SOL will open right away。
<b>GF510</b>	<b>100</b>	线扣 SOL 在 ON 和针极 C2 上的角度兼容性需要编程, 当捕线器规格模式设置为 GF518 = 1 时, 当线扣规格模式设置为 GF518 = 2 时, 是捕线器 SOL 的时间(单元 x 5mS)compaty of the angles of i thread catcher SOL in ON and needle pole C2 need to program, when thread catch specification mode set as GF518 = 1 when thread catch specification mode set GF518 = 2 is is time to thread catcher SOL (unitx 5mS)
<b>GF511</b>	<b>15</b>	当切线后, 电机转反向运行, 反向动作角度与机针前方位置(单位:度)为基本(针向上前方的对角与命令旋转方向)when after thread cut, motor turn opposite run, the opposite act angle with the front side of machine needle position (unit :degree) as basic (the counter angle of needle up front side with command rotate direction)
<b>GF512</b>	<b>202</b>	参考位置与所需上的缝角(由 2 个传感器学习改变参考)(低段) the sewing angle between refer position and need up (refer by 2 sensor learning to change) (low byte)
<b>GF513</b>	<b>2</b>	考位置与所需上的缝角(由 2 个传感器学习参考改变)(高段)the sewing angle between refer position and need up(refer by 2 sensor learning to change)(high byte)
<b>GF514</b>	<b>0</b>	ON:当针被 2 个传感器停止时, 停止角度按照 GF515。OFF:针停止角度按照 GF501ON : when needle stop by 2 sensors, stop angle follow GF515。OFF :needle stop angle follow GF501。
<b>GF515</b>	<b>140</b>	缝纫角度从针尖向下到防护装置旋转方向, 用于 2 个传感器(单位:0.25 度)the sewing angle from needle down point to guard command rotation direction , use for 2 sensors (unit : 0.25degree)
<b>GF516</b>	<b>82</b>	GF106 = 100, 踏板后退角度(单位:度)GF106 = 100, pedal step backward angle (unit : degree)
<b>GF518</b>	<b>1</b>	松线器规范模式设置 thread catcher specification mode setup 0:正常模式, 松线器不动作 0 : normal mode ,thread catch non-work。 1 : 线扣角度设置模式, 用针极角度 c1 激活扣线 SOL。从 C2 角度启动并操作, 然后关闭, 启动和操作角度为 C2, 然后关闭。剪线和第一次针脚后的功能(开始缝纫) 1 : thread catch angle setting mode, with needle pole angle C1activate thread catch SOL。 ·start and operate with angle C2 then off。function after thread cut and first needle foot (sewing start) 1 : 线扣时间设置方式, 用针极角度 c1 启动扣线 SOL, 在剪线(开始缝纫)后, 激活并运行 C2 然后关闭第一针脚函数。GF510 启动时间设置单元 isx 5mS 2 : thread catch time setup mode, with the angle of needle pole C1start thread catch SOL ·activate and run C2 then off the first stitch foot function after thread cut (sewing start) 。 GF510start time setup unit isx5mS

<b>GF519</b>	<b>0</b>	ON:1 针位检测模式 OFF:2 针位检测模式 ON : 1 needle sensor position detect mode OFF : 2 needle sensor position detect mode
<b>GF520</b>	<b>0</b>	GF519 = ON 时,原始信号在机针上。(1 个传感器) OFF:当 GF519 = OFFON when GF519 = ON, original signal is on machine needle。 (a sensor) OFF : when GF519 = OFF been setup
<b>GF522</b>	<b>0</b>	ON:高速位置(重新加速)OFF:正常位置 ON :high speed position (re-accelerate) OFF :normal position
<b>GF523</b>	<b>90</b>	上针传感器从上针点到下针点的缝制角度(CCW 角度, 单位[度])a needle up sensor sewing angel from needle up point to needle down point (CCW angle, unit[degree])
<b>GF602</b>	<b>12</b>	自动压脚持续时间(单位:[100ms])duration of auto FL (unit : [100ms])
<b>GF603</b>	<b>20</b>	压脚延迟时间(单位[ms](时间)delay time of FL (unit[ms] (time)
<b>GF604</b>	<b>5</b>	压脚连接延迟时间 pu1(单位[ms])the FL connecting delay time in pu1 (unit[ms])
<b>GF605</b>	<b>2</b>	电动时间(单位[ms])electric chopping time (unit[ms])
<b>GF606</b>	<b>2</b>	关闭时间设置(出发时间[毫秒])shut off time setup (departure time[ms])
<b>GF607</b>	<b>1</b>	ON:压脚在第一步关闭时打开。OFF:第一步关闭时压脚未打开 ON : FL open at the first step close。 OFF : FL not open at the first step close
<b>GF608</b>	<b>1</b>	ON:压脚在第二步关闭时打开。OFF:第二步关闭时压脚未打开 ON :FL open at the second step close。 OFF : FL not open at the second step close
<b>GF609</b>	<b>20</b>	电磁阀首次连接时间(单位[ms])first connecting time of solenoid valve (unit[ms])
<b>GF610</b>	<b>0</b>	ON:无踏板, 压脚打开(时间限制由 GF617 控制)OFF:无踏板, 压脚关闭 ON : pedal free and FL open (time limit control by GF617) OFF : pedal free and FL close
<b>GF611</b>	<b>0</b>	N:自动压脚时间不限 OFF:自动压脚时间按照 GF602 设置值 ON : auto FL time unlimited OFF : auto FL time follow GF602 setting value.
<b>GF613</b>	<b>0</b>	N:接通电源时自动压脚(时间无限), OFF:连接电源非自动压脚时 ON : when connecting power auto FL (time ∞) 。 , OFF : when connecting power non-auto FL。
<b>GF617</b>	<b>1</b>	ON:当 GF610 = ON 时, 时间限制为 30s。OFF:当 GF610 = ON 时, 时间不受限制 ON : when GF610 = On ,time limit is 30s OFF : when GF610 = ON, time unlimited
<b>GF701</b>	<b>0</b>	备用 T1 timer seq 6(单位[ms])spare timerT1 seq_6() (unit[ms])
<b>GF702</b>	<b>0</b>	备用 T2 timer seq 6(单位[ms])spare timerT2 seq_6() (unit[ms])
<b>GF703</b>	<b>0</b>	备用 T2 timer spare timerT3
<b>GF704</b>	<b>0</b>	2 次电磁铁报警 timer 1(单位[ms])2 times electric magnetic alarm timer1 (unit[ms])
<b>GF705</b>	<b>0</b>	2 次电磁铁报警 timer 2(单位[ms])2 times electric magnetic alarm timer2 (unit[ms])
<b>GF706</b>	<b>120</b>	正常进给数最大速度 1normal feed number max speed 1
<b>GF707</b>	<b>100</b>	正常进给数最大速度 2normal feed number2 max speed 2
<b>GF708</b>	<b>80</b>	正常进给数最大速度 3normal feed number max speed 3
<b>GF709</b>	<b>60</b>	最大进给速度 4common feed number max speed 4
<b>GF710</b>	<b>1</b>	ON:加速正确 B 规格:OFF:正确 A 规格 ON :acceleration correct B specification OFF : correct A specification
<b>GF711</b>	<b>10</b>	缝针设置 1sewing stitch setting 1
<b>GF712</b>	<b>10</b>	辅助针脚设置 2spare stitch setup 2
<b>GF713</b>	<b>0</b>	辅助针脚设置 3spare stitch setup 3
<b>GF714</b>	<b>0</b>	辅助针脚设置 4spare stitch setup 4
<b>GF715</b>	<b>1</b>	F 参数地址 L F parameter address L
<b>GF716</b>	<b>0</b>	F 参数地址 H F parameter address H
<b>GF717</b>	<b>80</b>	电机最大速度 motor max speed
<b>GF718</b>	<b>90</b>	电机最大速度限制 motor max speed limit
<b>GF719</b>	<b>1</b>	N:上下交替带半针开关 OFF:上下交替带半针开关 OON : alternately up/down with half stitch switch OFF : alternately up half stitch switch
<b>GF720</b>	<b>0</b>	ON:无踏板时针位随机停止 OFF:无踏板时针位

		ON : needle position stop randomly when pedal free OFF : needle position when pedal free
<b>GF721</b>	<b>0</b>	ON:低速区行程 mm 1 OFF:正常行程 ON : stroke -mm1 of low-speed area OFF : normal stroke
<b>GF722</b>	<b>0</b>	N:激活外部踏板传感器信号 OFF:内部踏板传感器信号 ON : activate outside pedal sensor signal OFF : inside pedal sensor signal
<b>GF723</b>	<b>0</b>	ON:后 1 步踏板动作切线 OFF:后 2 步踏板动作切线 ON :back 1 step pedal to act thread cut OFF : 2 steps back pedal to act thread
<b>GF724</b>	<b>0</b>	ON:压脚关闭延迟时间固定为 150 ms OFF:压脚关闭延迟时间为 GF603 设置时间 ON : FL close delay time fixed as 150 ms OFF : FL close delay time as GF603 setup time。
<b>GF725</b>	<b>0</b>	ON:压脚默认开启时间固定为 500 ms OFF:压脚默认开启时间设置为 GF609 设置值 ON : FL default ON time fixed as 500 ms OFF : FL default ON time set as GF609 setup value
<b>GF727</b>	<b>1</b>	:剪线后不自动上线, 1:剪线后自动上线, 2:剪线后自动上线, 并返回到复位时间 0 : no auto up after thread cut, 1 : auto up after thread cut, 2 : auto up after thread cut, with return again to reset time
<b>GF728</b>	<b>1</b>	切线回角度:0:20 度 1:30 度 2:45 度 3:60 度 4:75 度 5:90 度 6:105 度 turn back angle of thread cut : 0:20 degree 1:30degree 2:45degree3:60degree4:75degree5:90degree6 : 105degree
<b>GF729</b>	<b>0</b>	ON:GF874[度]添加一个角度从传感器的针尖停止角度:OFF:不添加 ON : GF874 [degree] adding an angle from the needle point of a sensor to stop angle : OFF : non-add
<b>GF730</b>	<b>0</b>	ON:检测底部线程左型号 OFF:不检测底部线程左型号 ON : detect bottom thread left model OFF : non-detect bottom thread left model。
<b>GF731</b>	<b>0</b>	ON:驱动 BT / 压脚 不切 OFF:驱动 BT / 压脚切 ON :drive BT / FL non-chopping OFF :drive BT / FL chopping
<b>GF732</b>	<b>0</b>	ON:开启 KE_300 的液位控制 OFF: KE_300 的非液位控制 ON : activate FL control on KE_300 OFF : non FL control on KE_300
<b>GF733</b>	<b>25</b>	常量 : T1 constant : T1 (unit[100ms])
<b>GF734</b>	<b>10</b>	常量 : T2 constant : T2 (unit : [100ms])
<b>GF735</b>	<b>25</b>	常量 : T3 constant : T3 (unit[100ms])
<b>GF736</b>	<b>2</b>	常量 : T4 constant : T4 (unit[100ms])
<b>GF737</b>	<b>8</b>	常量 : T5 constant : T5 (unit[100ms])
<b>GF740</b>	<b>0</b>	C 参数 C parameter 0L
<b>GF741</b>	<b>0</b>	C 参数 C parameter 0H
<b>GF742</b>	<b>10</b>	C 参数 C parameter 1L
<b>GF743</b>	<b>0</b>	C 参数 C parameter 1H
<b>GF744</b>	<b>0</b>	C 参数 C parameter 2L
<b>GF745</b>	<b>0</b>	C 参数 C parameter 2H
<b>GF746</b>	<b>0</b>	C 参数 C parameter 3L
<b>GF747</b>	<b>0</b>	C 参数 C parameter 3H
<b>GF748</b>	<b>0</b>	C 参数 C parameter 4L
<b>GF749</b>	<b>0</b>	C 参数 C parameter 4H
<b>GF750</b>	<b>0</b>	C 参数 C parameter 5L
<b>GF751</b>	<b>0</b>	C 参数 C parameter 5H
<b>GF752</b>	<b>0</b>	C 参数 C parameter 6L
<b>GF753</b>	<b>0</b>	C 参数 C parameter 6H
<b>GF754</b>	<b>0</b>	C 参数 C parameter 7L
<b>GF755</b>	<b>0</b>	C 参数 C parameter 7H
<b>GF756</b>	<b>0</b>	C 参数 C parameter 8L
<b>GF757</b>	<b>0</b>	C 参数 C parameter 8H



<b>GF758</b>	<b>0</b>	C 参数 C parameter 9L
<b>GF759</b>	<b>0</b>	C 参数 C parameter 9H
<b>GF760</b>	<b>0</b>	C 参数 C parameter 10L
<b>GF761</b>	<b>0</b>	C 参数 C parameter 10H
<b>GF762</b>	<b>0</b>	C 参数 C parameter 11L
<b>GF763</b>	<b>0</b>	C 参数 C parameter 11H
<b>GF764</b>	<b>0</b>	C 参数 C parameter 12L
<b>GF765</b>	<b>0</b>	C 参数 C parameter 12H
<b>GF766</b>	<b>0</b>	C 参数 C parameter 13L
<b>GF767</b>	<b>0</b>	C 参数 C parameter 13H
<b>GF768</b>	<b>0</b>	C 参数 C parameter 14L
<b>GF769</b>	<b>0</b>	C 参数 C parameter 14H
<b>GF770</b>	<b>0</b>	C 参数 C parameter 15L
<b>GF771</b>	<b>0</b>	C 参数 C parameter 15H
<b>GF772</b>	<b>0</b>	C 参数 C parameter 16L
<b>GF773</b>	<b>0</b>	C 参数 C parameter 16H
<b>GF774</b>	<b>0</b>	C 参数 C parameter 17L
<b>GF775</b>	<b>0</b>	C 参数 C parameter 17H
<b>GF776</b>	<b>0</b>	C 参数 C parameter 18L
<b>GF777</b>	<b>0</b>	C 参数 C parameter 18H
<b>GF778</b>	<b>0</b>	C 参数 C parameter 19L
<b>GF779</b>	<b>0</b>	C 参数 C parameter 19H
<b>GF780</b>	<b>0</b>	C 参数 C parameter 20L
<b>GF781</b>	<b>0</b>	C 参数 C parameter 20H
<b>GF813</b>	<b>0</b>	错误 1:9 锁 2:环力打开 3:AB 相断开 4:RST 断开打开相 5:电机高速运行 6:电机锁紧 7:电机电压过载 8:电磁阀错误 10:EEPROM sum check11:针位传感器错误 12:logo 错误 1latest error data 1 :9 locks 2 :loop force open 3 :AB phase disconnect 4 :RST disconnect open phase 5 : motor in high speed 6 : motor lock 7 : motor voltage over load 8 : solenoid valve error10 : EEPROM sum check11 : needle position sensor error12 : logo error
<b>GF815</b>	<b>0</b>	ON:除自动模式外,有织物时 PU2 不用。OFF:除自动模式外,有织物时 PU2 可用 ON : except auto mode, unuse PU2 when have fabric OFF : except auto mode, PU2 available when have fabric
<b>GF817</b>	<b>0</b>	缝纫控制单元检测方式 0-9 可选:缝纫控制单元检测方式(1:主控位置检查)11-99:10;ON 时间,1 位置;OFF 时间 sewing control unit testing mode can be chose form 0-9 : sewing control unit testing mode (1 : main-control place check) 11-99 : 10 ; ON time, 1position ; OFF time。
<b>GF818</b>	<b>4</b>	缝纫机锁紧时间检测时间(时间单位:100ms)sewing machine lock time detect time ( time unit : 100ms)
<b>GF819</b>	<b>50</b>	底线计数计时器设置值(单位[针数])bottom thread counting timer setup value (unit[stitch])
<b>GF820</b>	<b>0</b>	每单位底线的实际值(40 针/单位)real value of bottom thread in every unit (40 stitches/unit)
<b>GF822</b>	<b>12</b>	GF721 = ON, 最低低速区域使用数据(行程较短)GF721 = ON, the data of use for lowest the low-speed area (shorter the stroke)
<b>GF823</b>	<b>0</b>	ON:切断时旋转。关闭:当切断时不会旋转 ON :turn around when thread cut.Off :wont turn around when thread cut
<b>GF825</b>	<b>100</b>	限位拉动物 swin 速度(单位[s / min])limit the puller SWON speed (unit[s / min])
<b>GF826</b>	<b>1</b>	ON:按压和 1 针后 EBT 开始 OFF:按压和超过 3 针后 EBT 开始 ON :press and after 1 stitch EBT start OFF : press and more than 3 stitches then EBT start



<b>GF827</b>	<b>1</b>	ON:设置外部速度命令输入为最大速度设置 OFF:设置外部速度命令输入为外部速度命令处理 ON : set the outside speed command input into max speed setup OFF : set the outside speed command input as outside speed command to process
<b>GF830</b>	<b>1</b>	N:上电模式跟随(GF831)OFF:上电模式 1 跟随 ON : power on mode follow (GF831) OFF : follow from power on mode 1
<b>GF831</b>	<b>1</b>	电源源关闭时保存图案 save pattern when power shut off
<b>GF835</b>	<b>20</b>	GF839 = ON 时, 刷针控制缝线 the control stitches of needle wiper when GF839 = ON
<b>GF838</b>	<b>0</b>	ON:当退线切断负时, 针向上 OFF:当退线切断负时, 不能驱动 ON :when step back thread cut negative, needle up OFF : when step back thread cut negative, cant drive
<b>GF839</b>	<b>0</b>	ON:由缝线控制的计数 OFF:当打开 SW 时则正 ON : lama controled by stitches counting OFF : when open lama SW then lama positive
<b>GF841</b>	<b>1</b>	亮灯:普通模式、不缝模式、缝模式 灭灯:系列缝模式 light on : normal mode, non-sew, sewing mode light off : chain sewing mode
<b>GF842</b>	<b>0</b>	ON:在压脚 / ON 同时, 刹车停止同时 ON OFF:不跟随以下 ON :at same time of FL / ON, brake stop same time ON OFF : not follow belows
<b>GF843</b>	<b>0</b>	凹针线扎管顶部至前侧至 ON 位置的角度(单位[度])the angle from falt needle line tie tube top to front side reach the position of ON (unit[degree])
<b>GF844</b>	<b>90</b>	扎线管接通角度(单位[度])the ON angle of tie line tube (unit[degree])
<b>GF847</b>	<b>0</b>	ON:切带规格 OFF:不切带规格 ON : tape cut specification OFF : out of tape cut specification
<b>GF848</b>	<b>0</b>	ON:机械切带:OFF:1 次短切带 ON : mechanic tape cut : OFF : 1 time short tape cut
<b>GF849</b>	<b>0</b>	ON:提前后切 OFF:提前前切 ON : back cut in advance OFF : front cut in advance
<b>GF850</b>	<b>1</b>	ON:手动切断 OFF:自动切断 ON : manual cut OFF : auto cut
<b>GF851</b>	<b>0</b>	GF850 = ON: ON:背面切断 OFF:自动切断 when GF850 = ON :ON :back cut OFF :auto cut
<b>GF852</b>	<b>1</b>	ON:关闭电源时 gf831 设置无图案 OFF:在关闭电源时 gf831 设置图案 ON : GF831set without pattern when power shut down OFF : 在 GF831set pattern when power shut down
<b>GF854</b>	<b>0</b>	异常数据(第二个新数据) abnormal data (second new data)
<b>GF855</b>	<b>0</b>	异常数据(第三个新数据) abnormal data (third latest data)
<b>GF856</b>	<b>0</b>	异常数据(原始数据)abnormal data (original data)
<b>GF862</b>	<b>140</b>	最大转速最大值(单位[s / min])motor max speed max value (unit[s / min])
<b>GF863</b>	<b>0</b>	ON:织物检测/紧急停止动作→下电 OFF:织物检测/紧急停止动作→不启动 ON : fabric detect/emergency stop act→power off OFF : fabric detect/emergency stop act→non-start
<b>GF866</b>	<b>0</b>	ON:关闭段时传感器 B 输入断开, 电剪开启。ON off:关闭段时传感器 B 输入断开, 电剪不开启。ON off:关闭段 ON : electric chopping is ON when sensor B input is off during section close ON OFF : electric chopping is not ON when sensor B input is off during section close ON OFF : Section B close
<b>GF867</b>	<b>0</b>	GF839 = ON: ON:即使将 Pula SW 从 ON 开关设为 OFF, 仍然限制低速 OFF:当 Pula 从 ON 开关设为 OFF 时, 不限制低速 when GF839 = ON : ON : even set Pula SW from ON switch into OFF, it still limit the low speed OFF : when PULA from ON switch to OFF, not limit the low speed.
<b>GF870</b>	<b>1</b>	GF847 = ON(胶带切割规格)时, ON:半自动模式, 检测面料可激活 OFF:半自动模式, 检测面料无法激活 when GF847 = ON (tape cut specification) ON : semi-auto mode, detect fabric then could be activated OFF : semi-auto mode, detect fabric then could not be activated
<b>GF871</b>	<b>15</b>	外部速度设置转换模量(K_s):外部速度设置=外部速度设置=设置输入(0-255)x K_s + r_soutside speed setup convert modulus (K_s) : outside speed setup =outside speed setup =setup input (0-255) x k_s + r_s
<b>GF872</b>	<b>0</b>	外部速度设置输入为 0(单位[r / min])转速(r_s)outside speed setup input as 0 (unit[r / min]) rotate speed (r_s)
<b>GF874</b>	<b>10</b>	GF729 = ON 时, 对上针传感器下位置的角度值进行修正(加角度, 单位[度])when GF729 = ON, with an correction of angle value of the down position of needle up senor (plus angle,

		unit[degree])
<b>GF875</b>	<b>1</b>	ON:断开线时激活添加(GF876,GF877)OFF:断开线时不激活添加 ON : activate add when thread cut (GF876, GF877) OFF : non-activate add when thread cut
<b>GF876</b>	<b>8</b>	切线时间的速度差 speed difference add of thread cut time
<b>GF877</b>	<b>70</b>	切线时间的速度百分比 speed percentage add of thread cut time
<b>GF901</b>	<b>0</b>	ON:停止时间伺服锁正 OFF:停止时间伺服锁负 ON :stopping time servo lock positive OFF : stopping time servo lock negative
<b>GF902</b>	<b>36</b>	伺服锁最大扭矩值(0.28×e_servo_br [kg·cm])servo lock max Torque value (0.28× e_servo_br [kg·cm])
<b>GF904</b>	<b>8</b>	最小惯性常数值 min inertia constant value
<b>GF908</b>	<b>15</b>	减速位置时间, 每根针基本位置修正数据 decelerate position time, every needle in basic position correction data
<b>GF923</b>	<b>60</b>	加载惯性数据设置为加载惯性加速度 data of load inertia set to load inertia acceleration
<b>GF933</b>	<b>35</b>	速度百分比 speed percentage add
<b>GF935</b>	<b>40</b>	加速度加 accelerate add
<b>GF948</b>	<b>4</b>	位置增加 position percentage add
<b>GF949</b>	<b>1</b>	0:电机类型= SM 电机:维护电机 1:SD 电机:SD 电机 0 : motor type= SM motor : maintain motor1 : SD motor : Sd motor
<b>GF950</b>	<b>2</b>	极偶数量:2 个(4P), 3 个(6P)pole couple quantity : 2 (4P) , 3 (6P)
<b>GF952</b>	<b>75</b>	刹车停止时间(单位[ms])stopping time of brake to stop time (unit[ms])
<b>GF953</b>	<b>4</b>	电机机锁紧检测维护时间单位(单位:[100ms])motor lock detect maintain time unit (unit : [100ms])
<b>GF954</b>	<b>35</b>	百分比 so far percentage (KE300A : default= 15 * 10 * (100) = 15000)
<b>GF955</b>	<b>6</b>	积分加 so far integral add (KE300A : default= 20 * 10 = 200)
<b>GF956</b>	<b>85</b>	电流流检测添加 current detect add
<b>GF957</b>	<b>9</b>	电流检测右侧移动计数 current detect right side move count
<b>GF960</b>	<b>16</b>	速度积分加 speed integral add
<b>GF964</b>	<b>8</b>	速度差速器添加 speed speed differential add
<b>GFA01</b>	<b>24</b>	开始切带系列命令数量#56 = 24#56start:thread cut series command quantity #56 = 24
<b>GFA05</b>	<b>0</b>	&tc_1
<b>GFA08</b>	<b>1</b>	&tc_2
<b>GFA11</b>	<b>2</b>	&tc_3
<b>GFA14</b>	<b>3</b>	&tc_4
<b>GFA17</b>	<b>4</b>	&tc_5
<b>GFA20</b>	<b>5</b>	&tc_6
<b>GFA23</b>	<b>6</b>	&tc_7
<b>GFA24</b>	<b>0</b>	结束#56 over
<b>GFA25</b>	<b>18</b>	开始切带系列命令数量#57 = 18#57 #57 start : thread cut series command quantity #57 = 18
<b>GFA26</b>	<b>134</b>	另有规定 NOP
<b>GFA27</b>	<b>0</b>	另有规定 NOP
<b>GFA28</b>	<b>50</b>	等待时间 Waiting time50x2=100mS
<b>GFA29</b>	<b>3</b>	6ms
<b>GFA30</b>	<b>134</b>	等待时间 Waiting time15x2=30mS
<b>GFA31</b>	<b>1</b>	分开切 cut separate off
<b>GFA32</b>	<b>40</b>	40mS

GFA33	134	等待时间 Waiting time
GFA34	0	SOL OFF
GFA35	134	6ms
GFA36	0	等待时间 Waiting time
GFA37	2	打开 turn on
GFA38	2	76ms
GFA39	134	等待时间 Waiting time
GFA40	0	SOL OFF
GFA41	3	6ms
GFA42	0	# 57 end
GFA43	21	( # 58start : thread cut item # 58 (= 21) command quantity) ←not use now
GFA51	134	C1
GFA52	0	C2
GFA53	25	C3
GFA54	0	C4
GFA55	9	C5
GFA56	128	C6
GFA63	0	(over # 58)
GFA64	25	切线时间 Tc_1cutting time
GFA65	38	切线时间 Tc_2 cutting time
GFA66	25	松线时间 Tc_3 thread relax stroke losing time
GFA67	38	松线时间 Tc_4 thread stroke losing time
GFA68	25	拔线时间 Tc_5 thread wipe time
GFA69	38	拔线时间 Tc_6 thread wipe time
GFA70	80	压脚时间 Tc_7 Time to FL

#### 4.各种显示面板操作说明 Various display panel operation instruction

位置 Position	缝纫机型 Sewing machine type	图示 Diagram
	绷缝车用 Interlock Machine	
	包缝/拼缝用 Overlock Machine/Arm Interlocks	
	定位用 Positioning	

## 5.故障排除 Troubleshooting

先检查接地是否可靠 First, make sure that the ground is connected securely

如果按此表不能发现故障，修理前一定要切断电源 If you are not able to locate the defect according to the table, be sure to turn the power switch OFF before proceeding with servicing the unit

故障现象 Symptom of Malfunction	检查点 Checking Points	排除方法 Suggested Solutions
缝纫机不运行 The sewing machine does not run even after pedal-down.	电压是否正常? Is the supply voltage normal?	检查导线 Check for wiring.
	电源开关内的导体(从电源上取下开关后检查导体) Power switch conduction. (Check for conduction after removing the power switch from the power supply.)	如果接触不良, 更换开关 If the power switch is not conductive, replace it.
	接插件松动和没有插接插件 Loose connector and disconnection.	接好接插件 Insert the connector correctly and firmly.
	电源开启后, 指示灯不亮 The pilot lamp does not light up.	请销售者修理 Ask your sales shop for repair.
	保护电路工作 the protection circuit is actuated.	排除引起保护电路工作的故障重新接通电源 Remove the cause for which the protection circuit was actuated and turn the power switch ON once again.
高速时不工作 The machine does not run at a high speed.	最记限速 Maximum speed control. (Control box)	增加速度 Turn the knob clockwise.
	机器运行速度不稳定 The machine does not run smoothly.	最高速度限制(控制箱) Remove the cause for which the machine does not run smoothly.
	电压太低 The machine does not run smoothly.	检查电源线 Check the power supply wiring.
即使后踩踏板, 机器仍不工作 The machine does not run even after heeling back.	检查下针位停止时位置是否正确 Supply voltage drop and open phase of 3-phase power supply.	下针位停止后, 不要用手转动皮带轮。After needle-down stop, do not turn the pulley by hand.
即使踏板处于中性位置, 马达仍在工作或不能停在正确位置上。 Even when the pedal is placed in the neutral position, the motor does not stop or it does not stop in the correct position.	皮带张力 Belt tension.	重新调整 Re-adjust the belt.
	皮带轮松动 The pulley is loose.	重新拧紧 Re-tighten the pulley.
	如果踏板轻轻后踩, 马达不运行。The motor stops if the pedal lever is heeled back slightly.	更换踏板传感器 Replace the pedal sensor.
	同步器没有连接好 The synchronizer is not connected.	连接好同步器 connect the synchronizer normally.
周边不工作 No solenoid works.	控制箱的三相缺相 Open-phase operation of 3-phase control box (Red or black lead wires or the push button switch are coming off.) Remove the power connector to check the voltage between the terminals.	检查导线 ★您使用单相电源时, 绿黄色线接地, 灰色蓝色线接交流 220v 电源。Check the wiring. * When you use the machine with single phase, wiring connections should be made so that the white and black lead wires of the push button switch are connected to the power supply.
其它现象 Other symptoms	局部照明灯泡上无电压 No voltage of LED lamp develops.	检查导线和灯泡。Check the wiring, and examine the lamp.

- 异常显示

错误信息ER的显示与排除方法 **Information Error Code and Measurement:**

错误码 Error Code	异常现象 Abnormality Item	可能原因 Cause of The Problem	排除方法 Measure
E-1	针车被拘束、束缚 Sewing machine lock	针车被堵转 Sewing machine lock	检查修理机器 Check the sewing machine
		同步器信号异常及接头接触不良 Needle sensor connector is disconnected	正确可靠地连接同步器 Connect the needle sensor connector
		皮带松动 V-Belt has loose tension	皮带正确绷紧（参考安装说明） Tighten the belt(See page 4)
		马达接头松动及接触不良 Motor connector is disconnected	正确可靠地连接马达接头 Connect the motor connector
		针车头选择设定错误 Trimmer sequence is set improperly	重新选择针车头设定 Confirm trimmer sequence
E-2	控制箱过电流过电压保护 Hardware tripping in control	控制箱供电电压异常 Abnormal power supply voltage for control box	检查电源电压 Check the power-supply voltage
		高速至减速的过电压 High voltage at braking form high speed	必需修理电压控制回路、交换控制箱 Replace the control box to repair the regenerated circuit
E-3	马达编码器信号异常 Encoder signal of motor sensor is abnormal	马达编码器接头松动 Motor connector is disconnected	正确可靠的连接编码器接头 Connect the motor connector
			检查编码器线材 Check the wires of the motor sensor cable
E-4	马达驱动功能异常 Commutation signal of motor sensor is abnormal	马达编码器接头松动 Motor connector is disconnected	正确可靠的连接编码器接头 Connect the motor connector
			检查编码器线材 Check the wires of the motor sensor cable
			交换马达 Replace the motor
E-5	马达速度异常 Abnormal motor speed	控制箱异常 Abnormal control box	交换控制箱 Replace the control box
E-6	马达过负载 Motor over-load or lock	针车负荷重 Machine has heavy load	针车过负载原因排除 Check the machine load. If yes, reduce the machine load
		马达接头松动 Motor connector is disconnected	正确可靠地连接马达接头 Connect the motor connector
E-7	马达过电压 High voltage supply	控制箱的电源电压异常 Power supply voltage abnormal	交换控制箱 Exchange control Box
E-8	车头线圈异常 Abnormal Solenoid.	车头线圈短路 Solenoid is short-circuited	检查车头线圈 Check the solenoid.
E-10	控制箱传输接口异常 Control Box memory is abnormal.	EEPROM 数据信息错误 EEPROM has wrong data.	交换控制箱、或重新 Reset EEPROM by using (RESET) node.
E-11	控制箱与选针盒通信异常, 定位器定位模式设定错误 Abnormal Communication	选针盒线材松动, 定位器设定定位模式错误 The console is cable was plugged in after power on	关电源、正确可靠地连接选针盒接头后、或重新设定定位模式, 再开电源 Plug in the console cable with power off, then power on.
SAFE	安全开关异常 Safety Switch	下切刀保护开关工作, 安全开关损坏 安全开关出力方式错误（常开 or 常闭） Trimming protection, Safety switch broken, Safety switch setting incorrect (open or close)	正确可靠的安装下切刀, 检查开关是否损坏, 一般为常闭方式, 需修改参数请参照参数内容表 A14. Correct trimming device to be used, Check if the switch is damaged, Usually set to close, use A14 to adjust

## 6.专用参数 Special parameter

### 1.大和 AZ8003SD/ABT-A/D9 with 114-393US

F 組	初期值	設定内容
GF18	5	开关触发值 Finger Switch IN
GF19	7	
GF38	15	机器运行信号从 AUX1 输出 Machine Run Signal OUT from AUX1
GF39	0	
GF40	15	MT 切断信号从 AUX2 输出 MT Cutter OUT from AUX2
GF41	6	
GF46	15	自动速度输出 Auto Speed OUT
GF47	15	
GF106	57	UT 顺序 UT Sequense
GF132	400	定针停止位置 Positioning Speed for Stop
GF134	5100	起停速度 Start & End BT Speed
GF152	0	后踏感值 Sense of Full Heel Back
GF168	1	发现没布料不起动 Machine won't start without fabric
GF170	0	设为 0 时, 在 GF402 项加 10 针 If GF170=0, 10 stitches is plussed on GF402
GF402	9	开始回缝的针数 Stitch number of Start Backlatch
GF405	1	设为 1 时, 开始 BT Start BT is ON
GF406	2	设为 2 时, 结束 BT End BT is OFF
GF409	1	
GF411	10-15	停机数针 Stitch number for machine Stop at end
GF412	0	延时针数 Stitch number for next process
GF427	30	切线时间 Cutter ON time
GF441	1	设为 1, 电眼启动 Operate by Phot sensor
GF481	0	进入 UT 后结束 Go to UT sequence at end
GF607	1	后踩半抬压脚 Foot Lifter UP with half Heel Back
GF611	1	抬压脚时间 Time of Foot Lifter ON
GF727	1	设为 1, 自动抬压脚 Auto Foot Lifter ON
GF831	4	模式 4Pattern 4
GF847	0	切割 Tape Cut program
GF850	0	设为 0, 自动切割 Auto Tape Cut
GF851	1	设为 1, 半自动运行 Semi auto for Machine run
GF870	0	感应电眼无动作 Invalidates start by Sensing edge
GFA25	14	UT 的切线输出 Cutter program OUT from UT
GFA26	134	等待时间 Waiting time
GFA27	0	
GFA28	50	50x2=100mS
GFA29	134	切线启动 Cutter ON
GFA30	33	
GFA31	15	15x2=30mS
GFA32	134	切线结束及等待 Cutter OFF and Waiting
GFA33	1	



<b>GFA34</b>	<b>5</b>	
<b>GFA35</b>	<b>134</b>	
<b>GFA36</b>	<b>0</b>	
<b>GFA37</b>	<b>50</b>	50x2=100mS
<b>GFA38</b>	<b>0</b>	
<b>GFA39</b>	<b>255</b>	

## 2. 大和 VFS2511-156M/BAF/D9

<b>F 組</b>	<b>初期値</b>	<b>設定内容</b>
<b>GF12</b>	<b>0</b>	
<b>GF13</b>	<b>0</b>	
<b>GF18</b>	<b>8</b>	开关触发值 Finger Switch IN
<b>GF19</b>	<b>0</b>	
<b>GF38</b>	<b>0</b>	机器运行信号从 AUX1 输出 Machine Run Signal OUT from AUX1
<b>GF39</b>	<b>8</b>	
<b>GF40</b>	<b>14</b>	MT 切断信号从 AUX2 输出 MT Cutter OUT from AUX2
<b>GF41</b>	<b>0</b>	
<b>GF46</b>	<b>15</b>	自动速度输出 Auto Speed OUT
<b>GF47</b>	<b>15</b>	
<b>GF106</b>	<b>57</b>	UT 顺序 UT Sequense
<b>GF154</b>	<b>0</b>	
<b>GF155</b>	<b>0</b>	
<b>GF168</b>	<b>0</b>	发现没布料不起动 Machine won't start without fabric
<b>GF193</b>	<b>1</b>	
<b>GF194</b>	<b>0</b>	
<b>GF405</b>	<b>2</b>	设为 2 时，开始 BT Start BT is ON
<b>GF406</b>	<b>2</b>	设为 2 时，结束 BT End BT is OFF
<b>GF409</b>	<b>1</b>	
<b>GF411</b>		停机数针 Stitch number for machine Stop at end
<b>GF412</b>	<b>0</b>	延时针数 Stitch number for next process
<b>GF427</b>	<b>70</b>	切线时间 Cutter ON time
<b>GF441</b>	<b>1</b>	设为 1，电眼启动 Operate by Phot sensor
<b>GF481</b>	<b>0</b>	进入 UT 后结束 Go to UT sequence at end
<b>GF482</b>	<b>1</b>	
<b>GF483</b>	<b>10</b>	
<b>GF503</b>	<b>0</b>	
<b>GF519</b>	<b>1</b>	
<b>GF520</b>	<b>1</b>	
<b>GF717</b>	<b>4000</b>	
<b>GF718</b>	<b>4500</b>	
<b>GF727</b>	<b>1</b>	设为 1，自动抬压脚 Auto Foot Lifter ON
<b>GF825</b>	<b>2550</b>	
<b>GF831</b>	<b>4</b>	模式 4Pattern 4
<b>GF847</b>	<b>0</b>	切割 Tape Cut program
<b>GF848</b>	<b>0</b>	

GF849	0	
GF850	0	设为 0, 自动切割 Auto Tape Cut
GF851	0	设为 0, 自动运行 Semi auto for Machine run
GF862	4500	限速 Limite de Velocidad
GF923	60	加速度 Load inertia (Set as acceleration)
GF933	40	速度比例 Velocity proportional
GF960	140	速增益 Velocity integral gain
GFA25	18	UT 的切线输出 Cutter program OUT from UT
GFA26	128	等待时间 Waiting time
GFA27	128	
GFA28	130	130x2=260mS
GFA29	5	切线启动 Cutter ON
GFA30	134	
GFA31	1	1x2=2mS
GFA32	40	切线结束及等待 Cutter OFF and Waiting
GFA33	134	
GFA34	0	
GFA35	3	
GFA36	134	
GFA37	2	2x2=4mS
GFA38	38	
GFA39	134	
GFA40	0	
GFA41	3	
GFA42	0	

### 3.大和 vc 2700sD/UT-A34/BAF / CS / D9

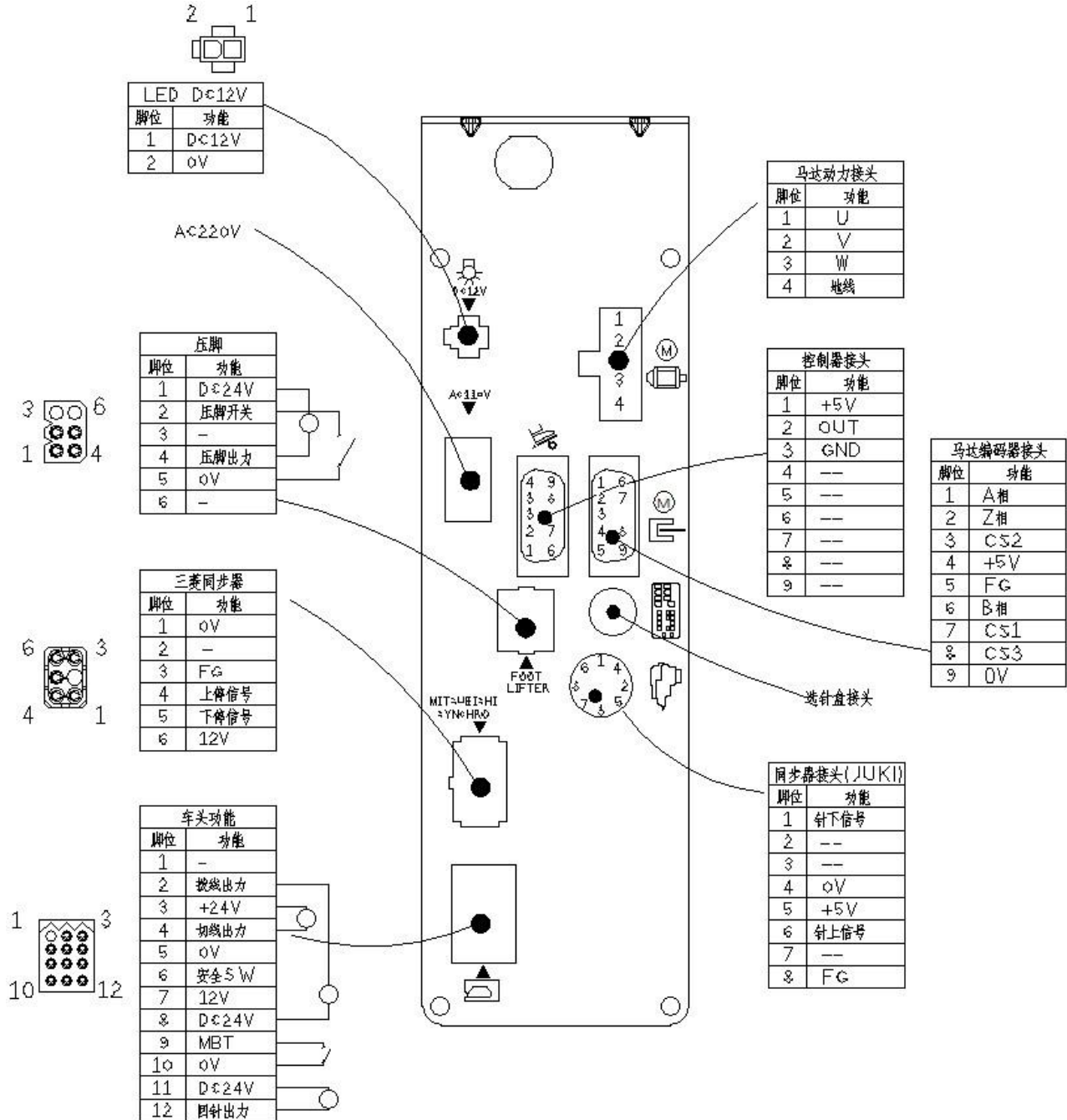
F 組	初期值		設定内容
	D8	D9	
GF12	112	8	
GF13	6	6	
GF20	112		
GF21	6		
GF22	115		
GF23	2		
GF26	115		
GF27	1		
GF28	115		
GF29	2		
GF38		15	
GF39		1	
GF40		15	MT 切断信号从 AUX2 输出 MT Cutter OUT from AUX2
GF41		2	
GF44		8	

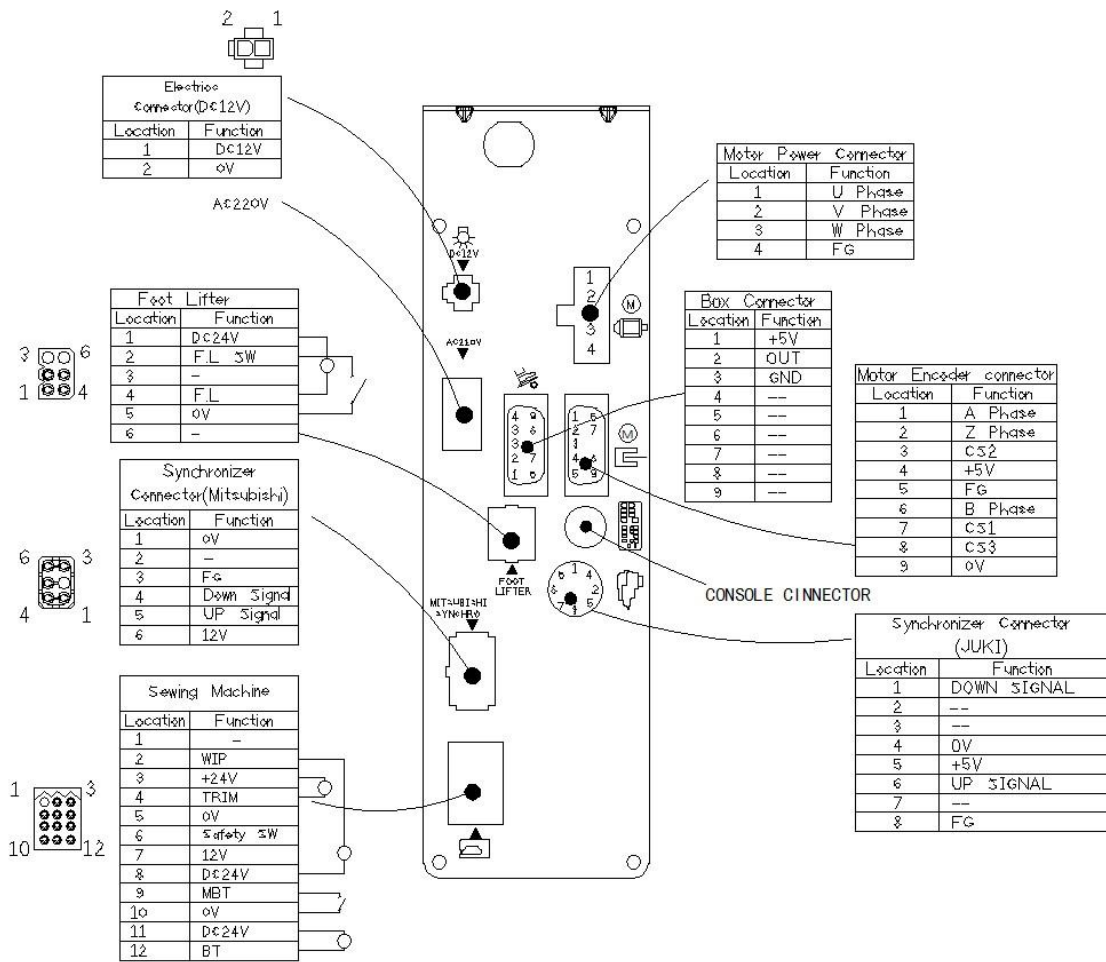
GF45		6	
GF46		15	自动速度输出 Auto Speed OUT
GF47		2	
GF106	74	57	UT 顺序 UT Sequense
GF111		2	FRONT CS OFF
GF112		1	
GF134	3000	3000	
GF135	6500		
GF136	5000	1020	
GF144	0	1	
GF157	0	No need	
GF163	0	1	
GF168		0	发现没布料不起动 Machine won't start without fabric
GF193		1	
GF403		4	0-9
GF404			Stitch
GF405	2	2	设为 2 时, 开始 BT Start BT is ON
GF406	1	0	设为 1 时, 结束 BT End BT is OFF
GF409		0	
GF411	30-50	30-50	停机数针 Stitch number for machine Stop at end
GF412	0	0	延时针数 Stitch number for next process
GF441	0	1	设为 1, 电眼启动 Operate by Phot sensor
GF481	1	0	进入 UT 后结束 Go to UT sequence at end
GF601	0		
GF717		7000	
GF718		7000	
GF727		1	设为 1, 自动抬压脚 Auto Foot Lifter ON
GF831	4	4	模式 4Pattern 4
GF862	70	7000	限速 Limite de Velocidad
GF869	0		
GFA25		18	UT 的切线输出 Cutter program OUT from UT
GFA26		128	等待时间 Waiting time
GFA27		128	
GFA28		130	130x2=260mS
GFA29		5	切线启动 Cutter ON
GFA30		134	
GFA31		1	1x2=2mS
GFA32		40	切线结束及等待 Cutter OFF and Waiting
GFA33		134	
GFA34		0	
GFA35		3	
GFA36		134	
GFA37		2	2x2=4mS
GFA38		38	
GFA39		134	

GFA40		0	
GFA41		3	
GFA42		0	

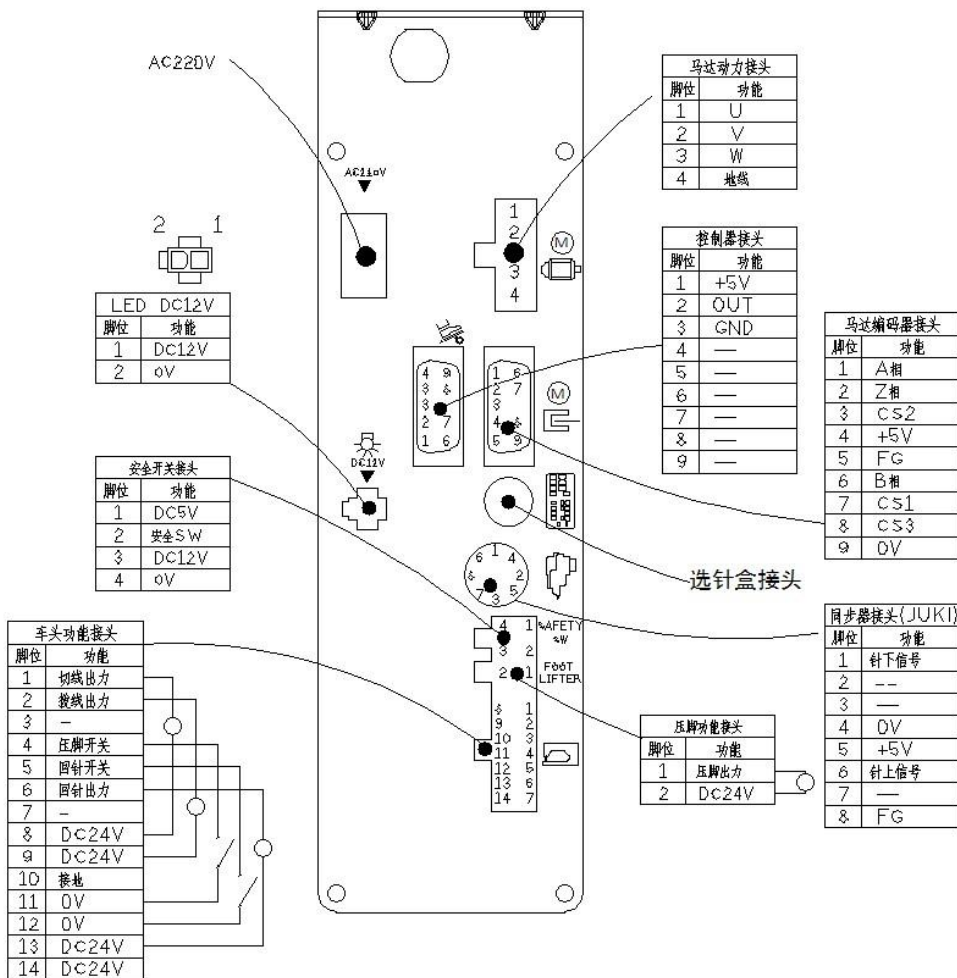
## 7.接线功能图Circuit Diagram

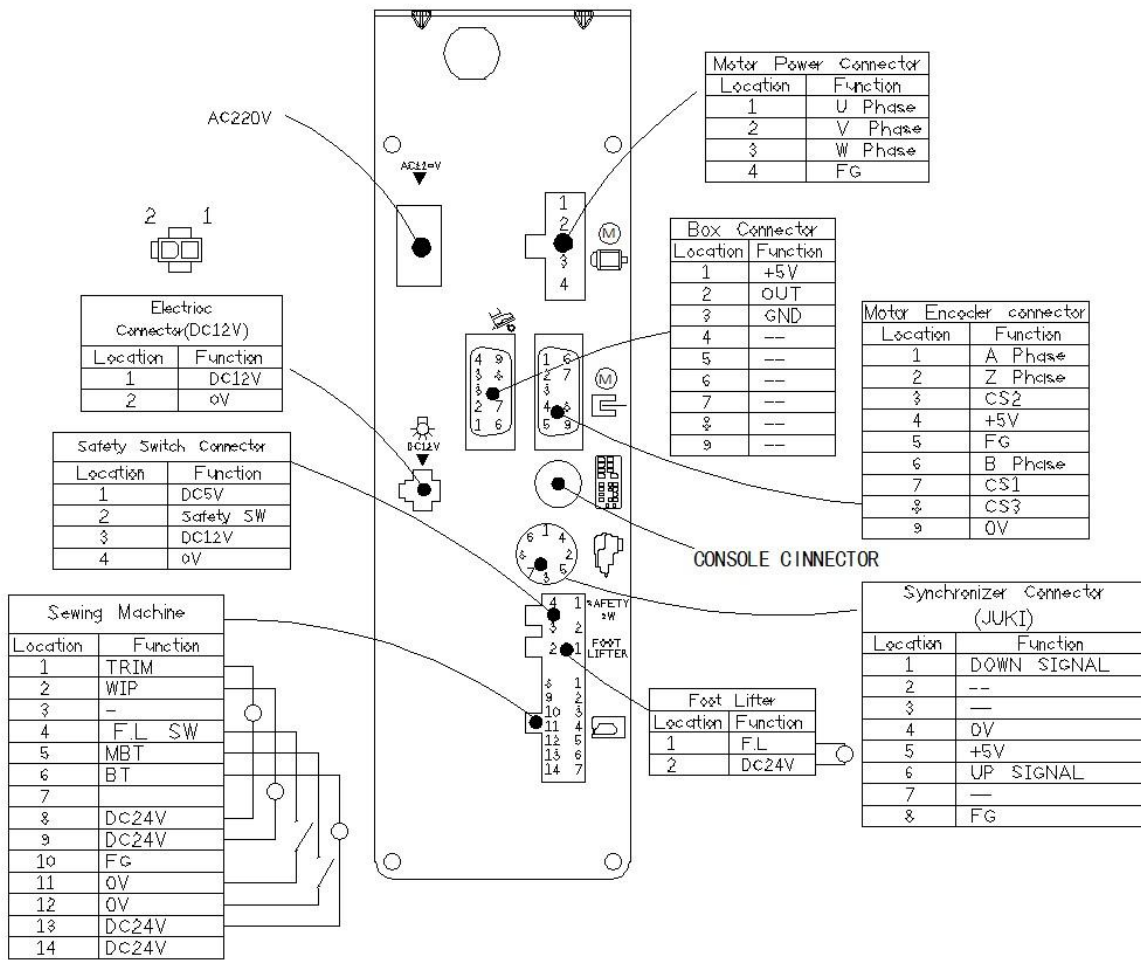
### 1.KE300M(三菱型平车)接线图KE300M(Think Material)Connecting Diagram



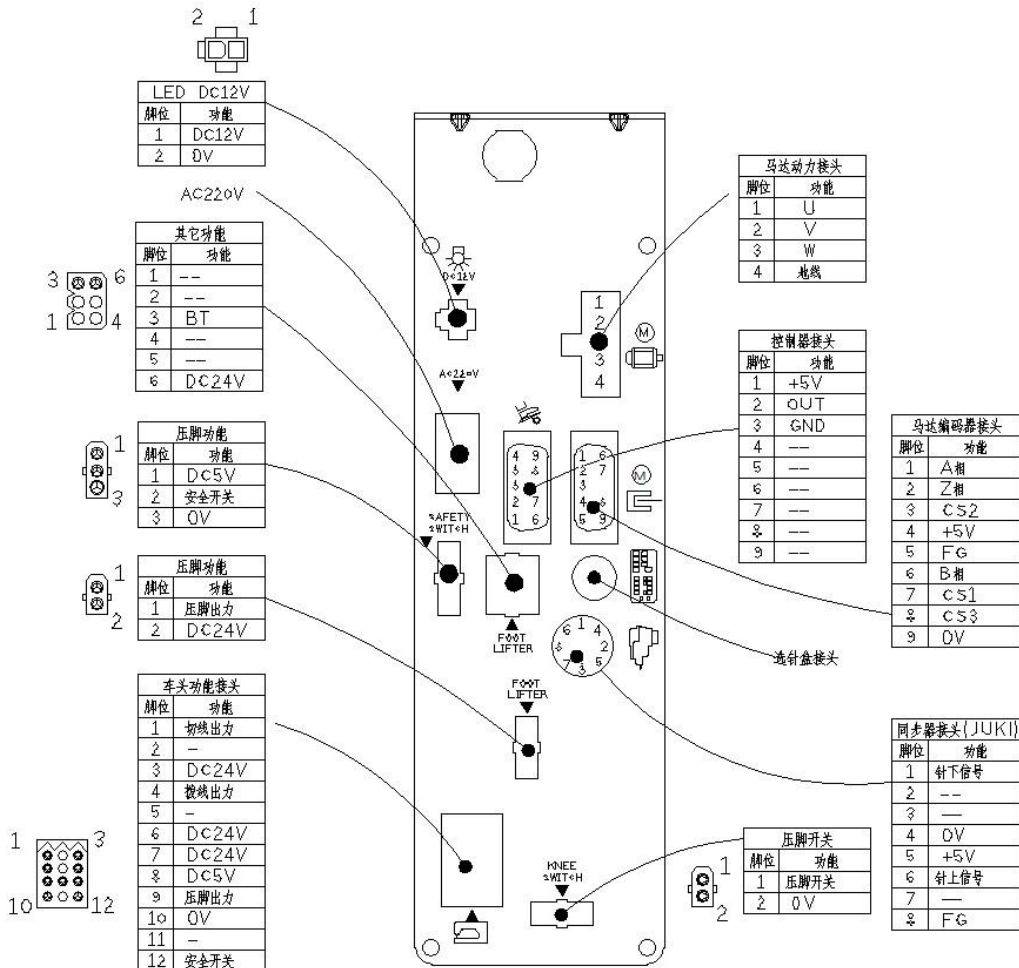


## 2.KE300A(重机型平车)接线图 KE300A(Lockstitch)Connecting Diagram

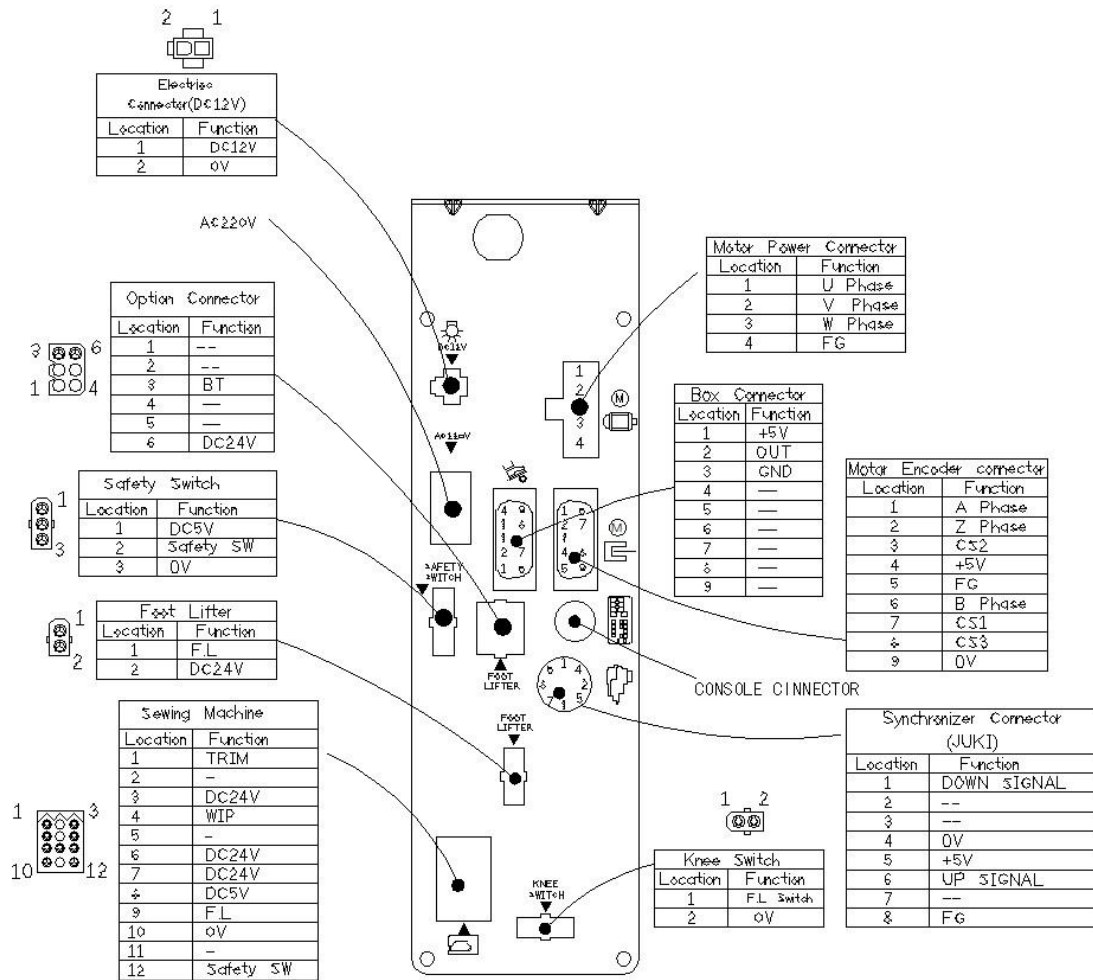




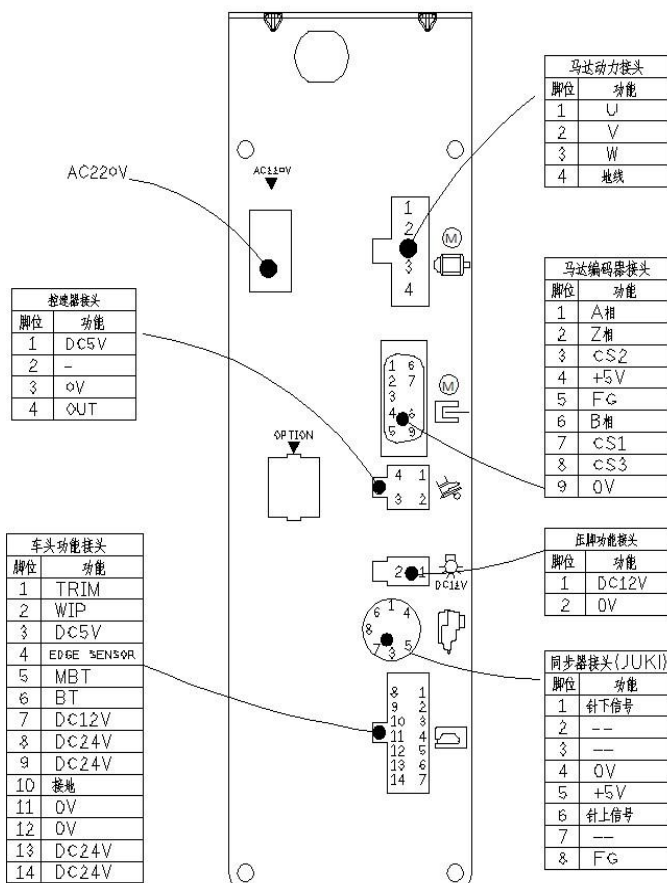
### 3.KE321B(一般绷缝车)接线图 KE321B(Chain Stitch Machine)Connecting Diagram

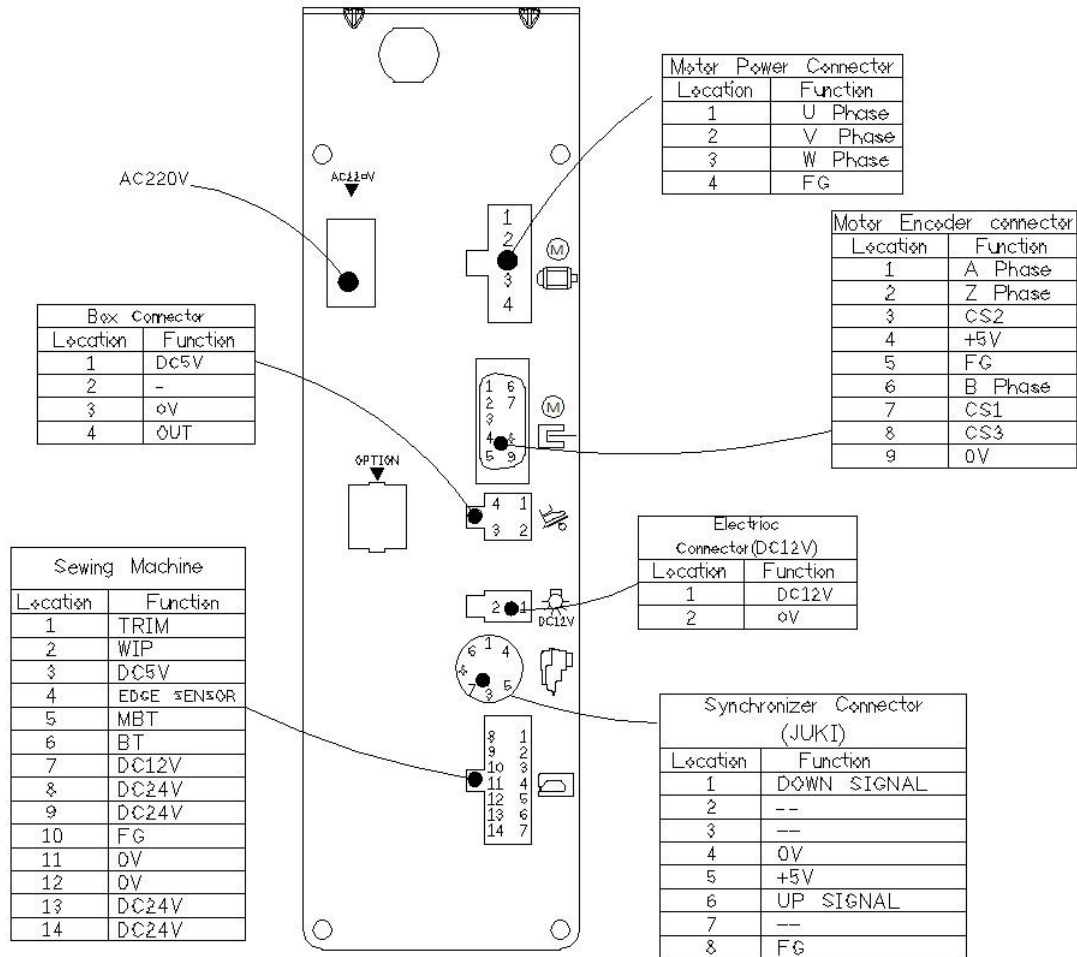




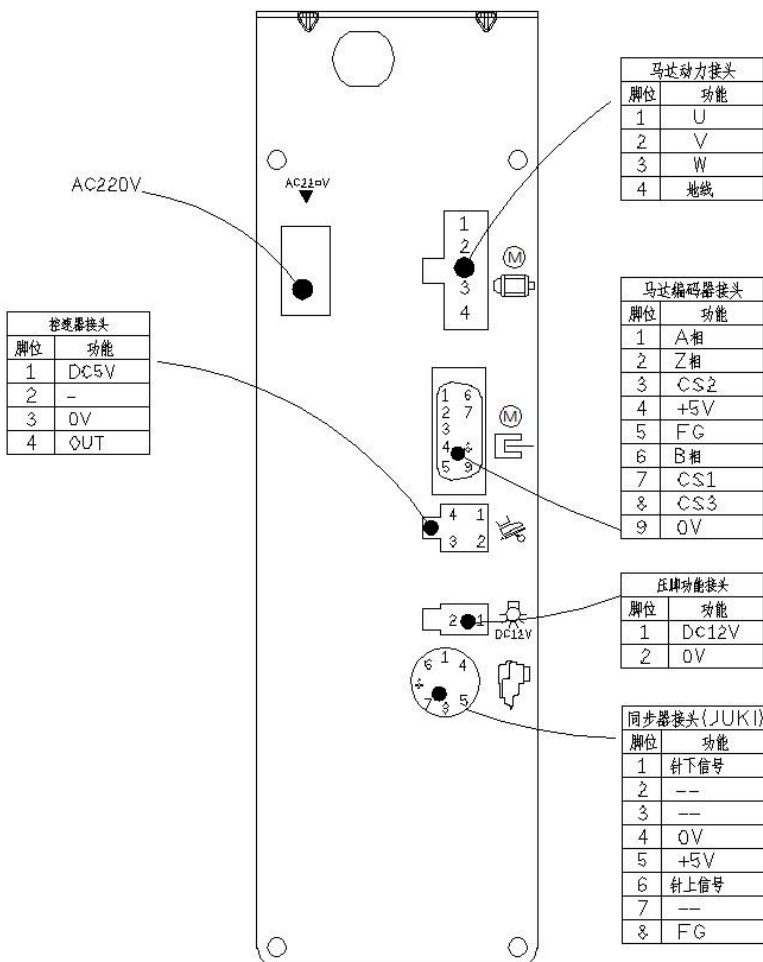


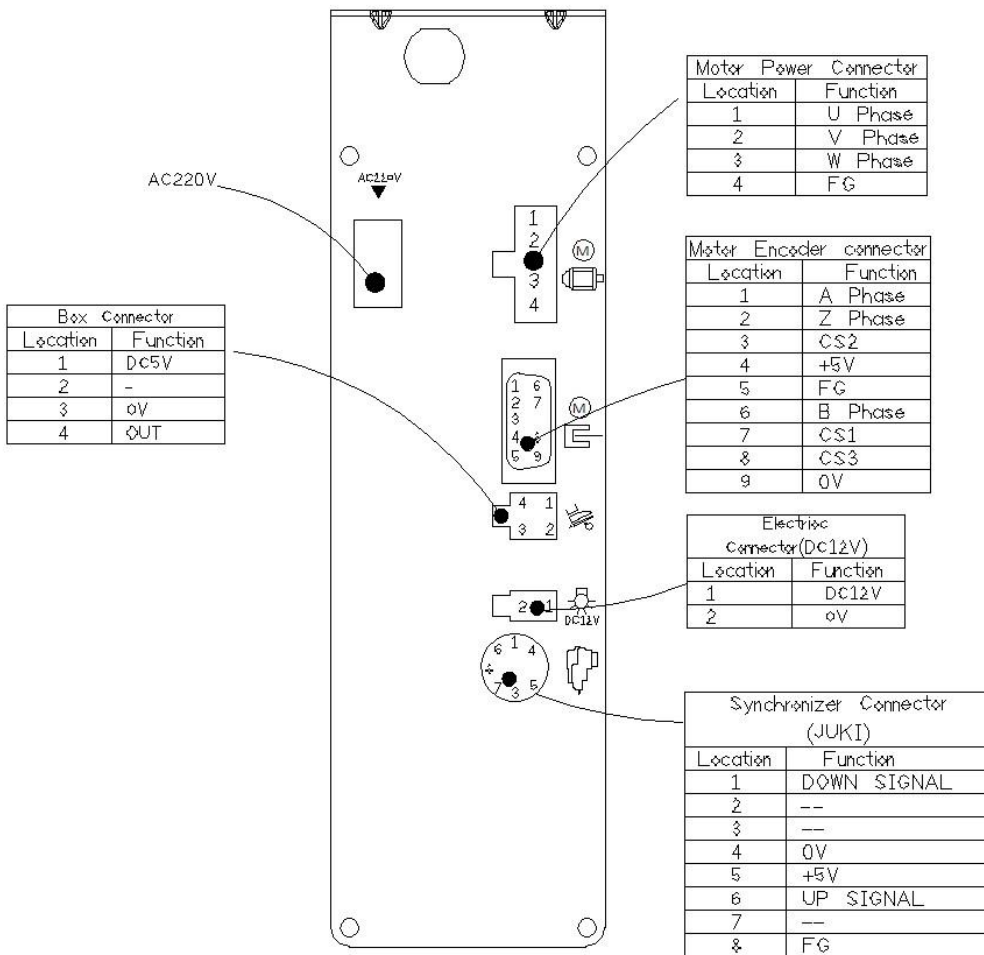
#### 4.KE151(一般包缝车)接线图 KE151( Overlock Machine)Connecting Diagram



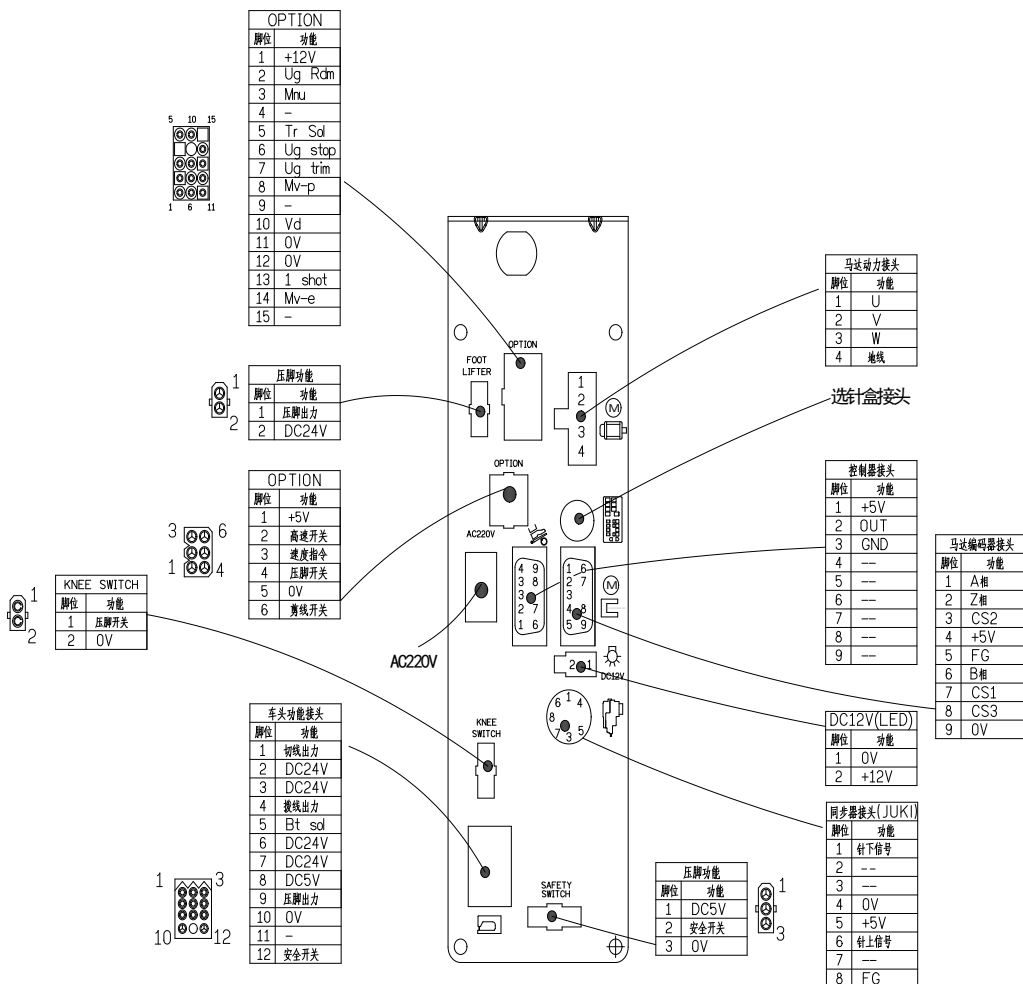


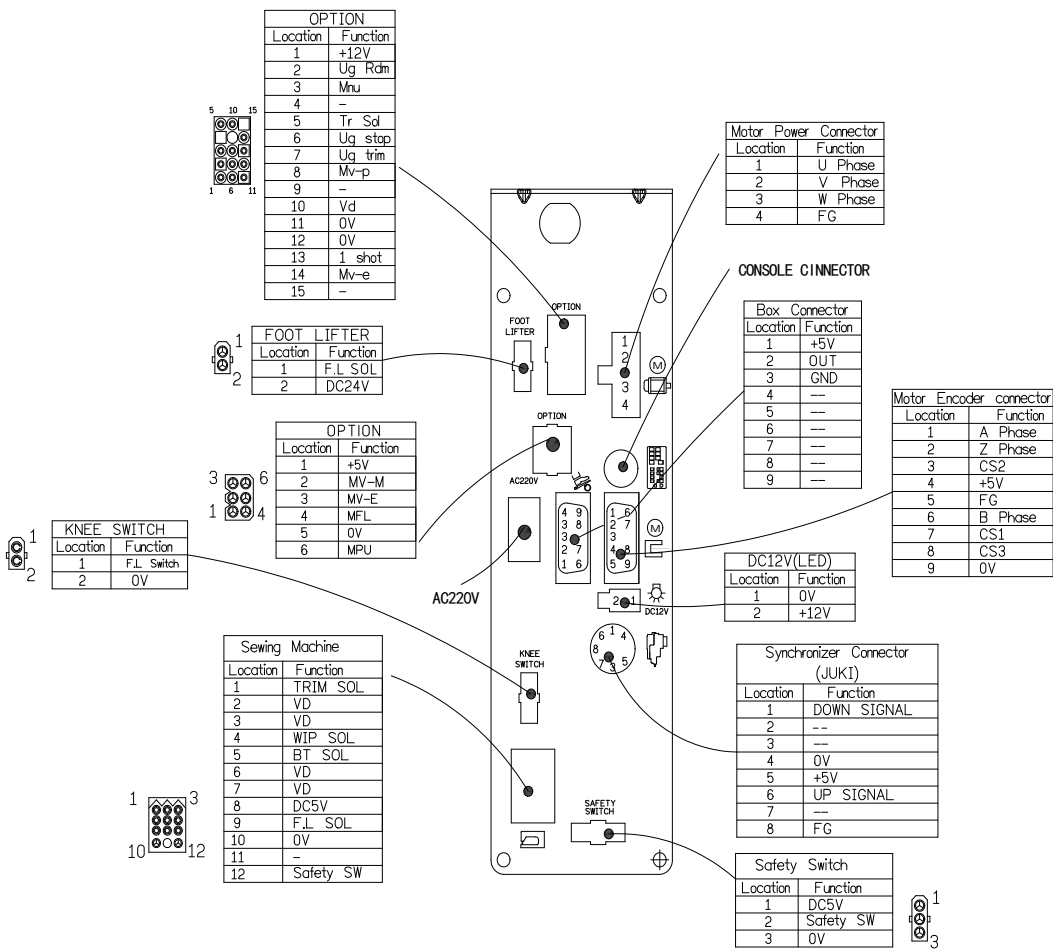
### 5. KE150NP(定位型)接线图 KE150NP(Needle Position)Connecting Diagram



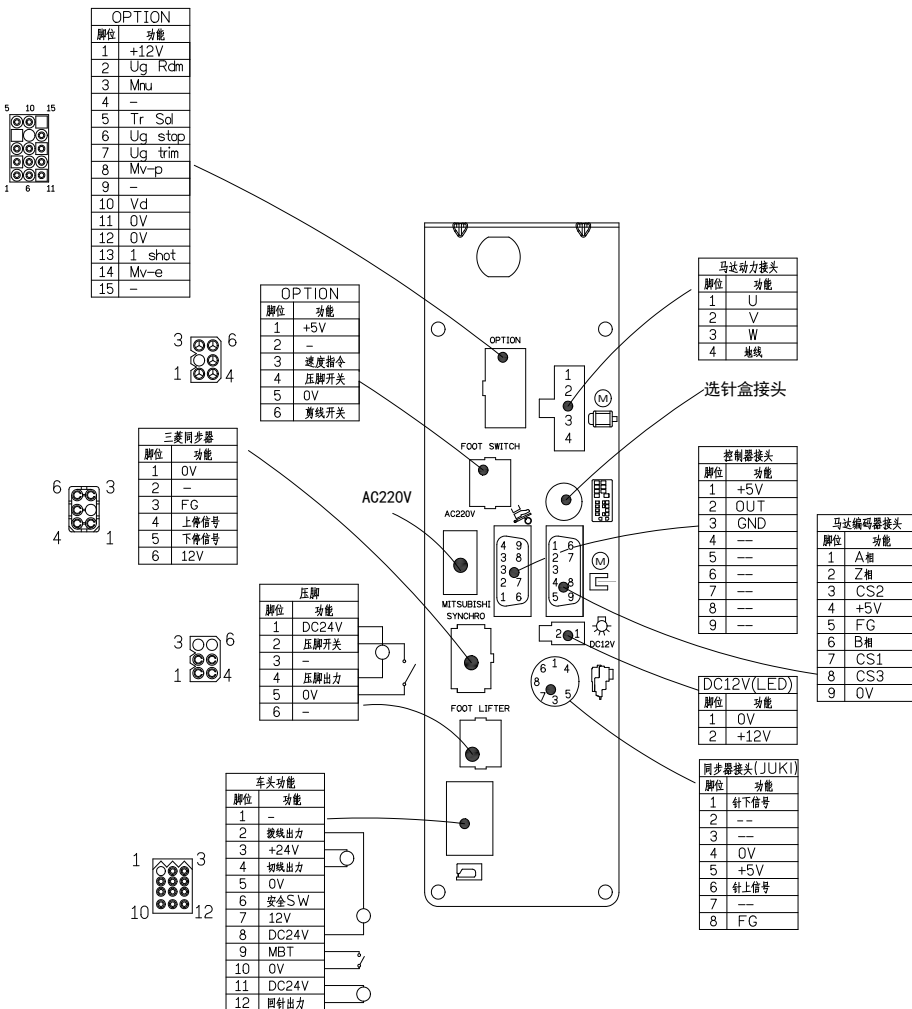


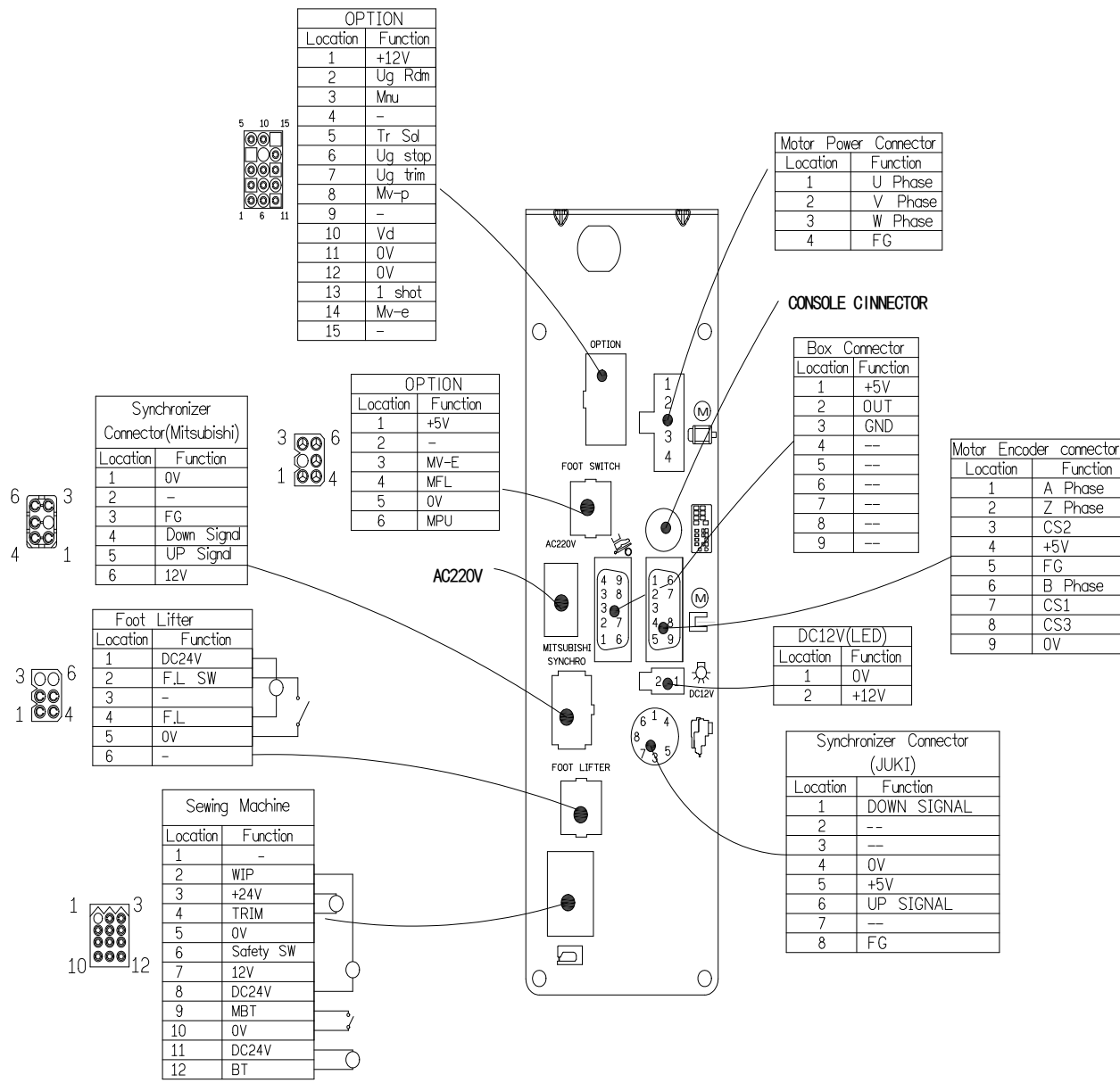
6.KE521-B(一般绷缝车)接线图 KE521-B(Chain Stitch Machine)Connecting Diagram





7.KE500-C(三菱型平车)接线图 KE500-C(Think Material)Connecting Diagram





**8. 显示器实际显示对照表 Segment Display characters comparison chart**

实际数值	0	1	2	3	4	5	6	7	8	9
七段显示器	0	1	2	3	4	5	6	7	8	9
英文数值	A	B	C	D	E	F	G	H	I	J
七段显示器	A	b	C	d	E	F	G	G	,	U
英文数值	K	L	M	N	O	P	Q	R	S	T
七段显示器	t	L	n	n	o	P	9	r	S	r
英文数值	U	V	W	X	Y	Z				
七段显示器	U	u	8	11	Y	≡				

<b>Actual Numbers</b>	0	1	2	3	4	5	6	7	8	9
<b>Display Numbers</b>	0	1	2	3	4	5	6	7	8	9

<b>Actual Numbers</b>	A	B	C	D	E	F	G	H	I	J
<b>Display Numbers</b>	A	b	C	d	E	F	G	G	,	U
<b>Actual Numbers</b>	K	L	M	N	O	P	Q	R	S	T
<b>Display Numbers</b>	L	L	n	n	o	P	q	r	S	r
<b>Actual Numbers</b>	U	V	W	X	Y	Z				
<b>Display Numbers</b>	U	U	8		Y	≡				